

This Page Is Inserted by IFW Operations
and is not a part of the Official Record

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

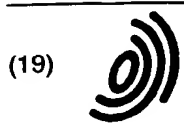
Defects in the images may include (but are not limited to):

- BLACK BORDERS
- TEXT CUT OFF AT TOP, BOTTOM OR SIDES
- FADED TEXT
- ILLEGIBLE TEXT
- SKEWED/SLANTED IMAGES
- COLORED PHOTOS
- BLACK OR VERY BLACK AND WHITE DARK PHOTOS
- GRAY SCALE DOCUMENTS

IMAGES ARE BEST AVAILABLE COPY.

As rescanning documents *will not* correct images,
please do not report the images to the
Image Problem Mailbox.

THIS PAGE BLANK (USPTO)



Europäisches Patentamt
European Patent Office
Office européen des brevets



(11) **EP 0 909 788 A1**

(12)

EUROPEAN PATENT APPLICATION

published in accordance with Art. 158(3) EPC

(43) Date of publication:
21.04.1999 Bulletin 1999/16

(21) Application number: 98911181.0

(22) Date of filing: 02.04.1998

(51) Int. Cl.⁶: **C08L 21/00**, C08K 3/04,
C08K 5/24, C08K 5/41,
B60C 1/00

(86) International application number:
PCT/JP98/01530

(87) International publication number:
WO 98/44040 (08.10.1998 Gazette 1998/40)

(84) Designated Contracting States:
**AT BE CH CY DE DK ES FI FR GB GR IE IT LI LU
MC NL PT SE**

(30) Priority: 02.04.1997 JP 84133/97
13.02.1998 JP 31751/98
13.02.1998 JP 31752/98
13.02.1998 JP 31753/98

(71) Applicants:
• **Bridgestone Corporation**
Tokyo 104-8340 (JP)
• **OTSUKA CHEMICAL COMPANY, LIMITED**
Osaka-shi, Osaka 540-0021 (JP)

(72) Inventors:
• **HOJO, Masahiro**
Tokyo 187-0031 (JP)
• **KUSANO, Tomohiro**
Tokyo 187-0031 (JP)
• **MATSUE, Akihiko**
Tokyo 187-0031 (JP)

- **SUGIMOTO, Kenichi**
Tokyo 187-0031 (JP)
- **KAMO, Shigeki**
Tokyo 187-0031 (JP)
- **TOMOTAKI, Yoshihisa**
Otsuka Chemical Co., Ltd.
Tokushima-shi Tokushima 771-0150 (JP)
- **OKA, Akinori**
Otsuka Chemical Co., Ltd.
Tokushima-shi Tokushima 771-0150 (JP)
- **HIRAYAMA, Ken**
Otsuka Chemical Co., Ltd.
Tokushima-shi Tokushima 771-0150 (JP)

(74) Representative: **Whalley, Kevin**
MARKS & CLERK,
57-60 Lincoln's Inn Fields
London WC2A 3LS (GB)

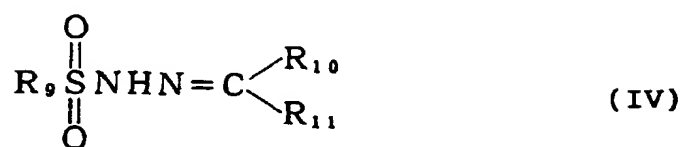
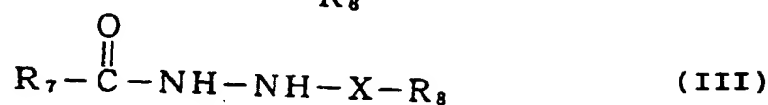
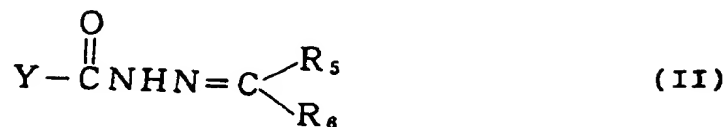
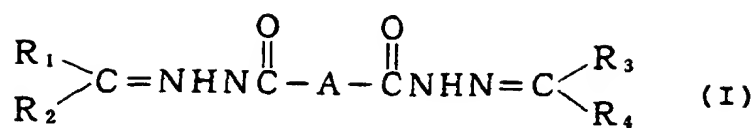
Remarks:

The applicant has requested a correction of the description.

(54) **RUBBER COMPOSITION AND PNEUMATIC TIRES**

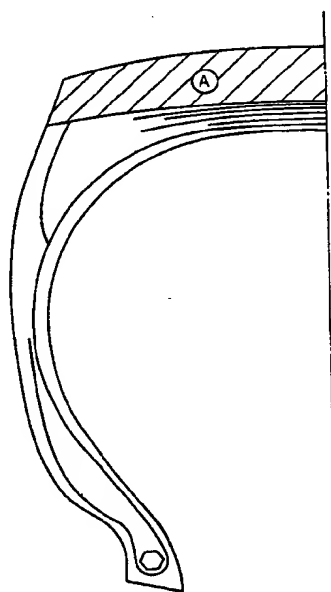
(57) A rubber composition prepared by compounding 0.05 to 20 parts by weight of at least one selected from substituted hydrazide compounds represented by the following Formulas (I) to (IV) per 100 parts by weight of a rubber component comprising at least one rubber selected from the group consisting of natural rubber and synthetic rubber, and a pneumatic tire using the same:

EP 0 909 788 A1



wherein A represents one selected from the group consisting of an aromatic group which may have a substituent, a hydantoin ring which may have a substituent, and a saturated or unsaturated linear hydrocarbon having 1 to 18 carbon atoms; Y represents hydrogen, an amino group, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group, an alkenyl group, an aromatic group, a pyridyl group or hydrazino group; and R_1 to R_{11} each represent hydrogen, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group or an aromatic group.

FIG. 1



A: TREAD PART

Description

Technical Field

- 5 [0001] The present invention relates to a rubber composition providing rubber products which are excellent in aging resistance, and a pneumatic tire.

Background Art

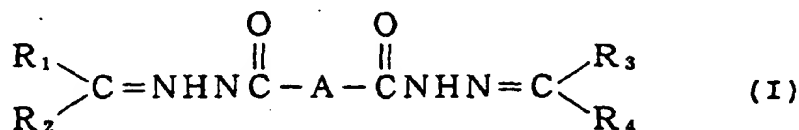
- 10 [0002] In order to prevent aging of rubber products using rubber compositions comprising natural rubber and/or synthetic rubber, various antioxidants have so far been developed.
- [0003] Further, in order to meet social demands for saving resources and energy in recent years, low heat generation property rubber compositions have actively been developed in the rubber industry.
- 15 [0004] In general, diphenyldiamine based and hindered phenol based compounds have so far been used as antioxidants. These compounds give H of >NH and -OH to peroxy radicals produced in a process of auto-oxidative degradation to deactivate them, and the compounds themselves turn to stable compounds through more stable radicals. Widely known is such a method that peroxy radicals are deactivated to cut off a radical chain reaction, whereby aging is prevented.
- 20 [0005] However, both the conventional diphenyldiamine based and hindered phenol based antioxidants described above have an aging-resistant action. In general, the aging-resistant effect increases according as the compounding amount is increased in a range where the compounding amount thereof is small. However, when they are used in large quantities, an increase in the effect gets slow gradually, and the effect is reduced by blooming in a certain case. Accordingly, amount to be used has to be properly restricted.
- 25 [0006] Further, the diphenyldiamine based antioxidants cause a large change rate of an elastic modulus of rubber before and after degradation of the rubber, and in a certain case, they harden the rubber markedly and deteriorate the rubber properties depending on the ingredients of the rubber composition and the conditions of degradation.
- [0007] On the other hand, with respect to the aging-resistant characteristics of hydrazide compounds, known are dihydrazide compounds displaying a green strength-improving effect (U.S. Patent 4124750), compounds which elevate ozone resistance and in which hydrogen parts of hydrazide and hydrazine are substituted (British Patent 909753) and compounds having an effect as stabilizers for oil extended rubber (British patent 1330393).
- 30 [0008] Further, it is described in Japanese Patent Publication No. Hei 7-57828 that specific hydrazide compounds can provide a rubber product with a low heat generation property effect and among these compounds, particularly isophthalic dihydrazide (IDH) and 3-hydroxy-2-naphthoic hydrazide can reveal a low heat generation property effect in small amounts.
- 35 [0009] However, the hydrazide compounds described in these publications, which are compounded into rubber compositions comprising a general sulfur-vulcanizing base rubber, shorten initiation of vulcanization reaction to a large extent and elevate the Mooney viscosity, so that the workability is damaged to a large extent. Accordingly, the compounding amount is restricted only to a small amount, and the satisfactory aging resistant effect is not obtained.
- 40 [0010] In light of the conventional problems described above, the present invention intends to solve them, and an object thereof is to provide a rubber composition providing rubber products having an excellent aging resistant characteristic and a rubber composition in which workability is not reduced when blended with sulfur vulcanizing agents used extensively in the rubber industry including tire.
- [0011] Another object of the present invention is to provide a low heat generation property rubber composition which can control an increase in the Mooney viscosity and enhance the workability while maintaining the low heat generation property.
- 45 [0012] In addition, a further object of the present invention is to provide a pneumatic tire having an excellent aging-resistant characteristic as well as an excellent low heat generation property.

Disclosure of the Invention

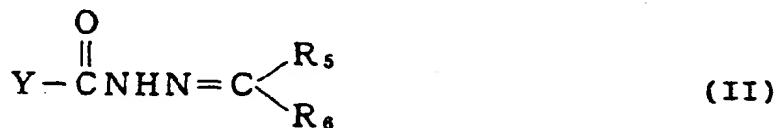
- 50 [0013] Intensive investigations of the conventional problems described above continued by the present inventors have resulted in newly finding that specific hydrazide compounds obtained as a result of modifying a hydrazide group by various methods so that an influence is not exerted on a vulcanization reaction can achieve the objects described above while maintaining an aging-resistant capability and that some of these compounds have a low heat generation property effect as well, and thus the present invention has come to complete.
- 55 [0014] That is, the present invention has the following constituents of (1) to (17):

(1) A rubber composition prepared by compounding 0.05 to 20 parts by weight of at least one selected from the

group consisting of hydrazide compounds represented by the following Formulas (I) to (IV) per 100 parts by weight of a rubber component comprising at least one rubber selected from the group consisting of natural rubber and synthetic rubber:



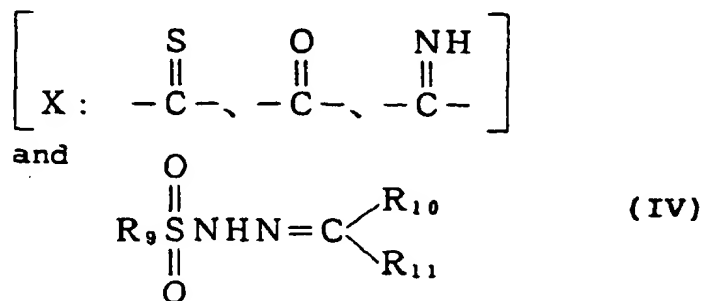
wherein A represents one selected from the group consisting of an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, a hydantoin ring which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, and a saturated or unsaturated linear hydrocarbon having 1 to 18 carbon atoms; R₁ to R₄ each represent hydrogen, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group or an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, and each of R₁ to R₄ may be the same or different, and when R₁ and R₂ and/or R₃ and R₄ are alkyl groups, R₁ may be bonded to R₂ and R₃ may be bonded to R₄ to form rings;



wherein Y represents hydrogen, an amino group, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group, an alkenyl group, an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, a pyridyl group or hydrazino group; R₅ and R₆ each represent hydrogen, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group, an alkenyl group or an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, and each of R₅ and R₆ may be the same or different, and when R₅ and R₆ are alkyl groups, R₅ may be bonded to R₆ to form a ring;



wherein R₇ and R₈ each represent an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group, an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, an alkenyl group, an amino group or an alkylamino group and each of R₇ and R₈ may be the same or different; and X represents a single bond or any of the groups represented by the following formulas;



wherein R_9 represents hydrogen, an alkoxy group, an amino group, a substituted amino group, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group, an alkenyl group or an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms; and R_{10} and R_{11} each represent hydrogen, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group, an alkenyl group or an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, and each of R_{10} and R_{11} may be the same or different, and when R_{10} and R_{11} are alkyl groups, R_{10} may be bonded to R_{11} to form a ring.

(2) The rubber composition as described in the above item (1), containing 30 phr or more of natural rubber (which may be polyisoprene rubber) as the rubber component.

(3) The rubber composition as described in the above item (1) or (2), prepared by further compounding 20 to 150 parts by weight of a reinforcing filler.

(4) The rubber composition as described in the above item (3), wherein the reinforcing filler is carbon black.

(5) The rubber composition as described in any of the above items (1) to (4), wherein A in Formula (I), Y in Formula (II), R_7 in Formula (III) and R_9 in Formula (IV) in the hydrazide compounds represented by Formulas (I) to (IV) described above represent a phenyl group (may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms) or a naphthyl group (may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms).

(6) The rubber composition as described in the above item (5), wherein the compound represented by Formula (I) described above is N^2, N^4 -di(1-methylethylidene)isophthalodihydrazide, N^2, N^4 -di(1-methylpropylidene)isophthalodihydrazide or N^2, N^4 -di(1,3-dimethylbutylidene)isophthalodihydrazide.

(7) The rubber composition as described in the above item (5), wherein the hydrazide compound represented by Formula (II) described above is N' -(1-methylethylidene)salicylohydrazide, N' -(1-methylpropylidene)salicylohydrazide, N' -(1,3-dimethylbutylidene)salicylohydrazide, N' -(2-furylmethylene)salicylohydrazide, 1-hydroxy- N' -(1-methylethylidene)-2-naphthohydrazide, 1-hydroxy- N' -(1-methylpropylidene)-2-naphthohydrazide, 1-hydroxy- N' -(1,3-dimethylbutylidene)-2-naphthohydrazide, 1-hydroxy- N' -(2-furylmethylene)-2-naphthohydrazide, 3-hydroxy- N' -(1-methylethylidene)-2-naphthohydrazide, 3-hydroxy- N' -(1-methylpropylidene)-2-naphthohydrazide, 3-hydroxy- N' -(1,3-dimethylbutylidene)-2-naphthohydrazide or 3-hydroxy- N' -(2-furylmethylene)-2-naphthohydrazide.

(8) The rubber composition as described in the above item (5), wherein the hydrazide compound represented by Formula (III) described above is N-benzoyl- N' -phenylhydrazide, 1-benzamidoguanidine or 1-benzoylsemicarbazide.

(9) The rubber composition as described in the above item (5), wherein the hydrazide compound represented by Formula (IV) described above is N' -(1-methylethylidene)benzenesulfonohydrazide, N' -(1-methylpropylidene)benzenesulfonohydrazide, N' -(1,3-dimethylbutylidene)benzenesulfonohydrazide, N' -(1-phenylethylidene)benzenesulfonohydrazide, N' -(2-hydroxybenzylidene)benzenesulfonohydrazide, N' -diphenylmethylenbenzenesulfonohydrazide, N' -(2-furylmethylene)benzenesulfonohydrazide, N' -(1-methylethylidene)-p-toluenesulfonohydrazide, N' -(1-methylpropylidene)-p-toluenesulfonohydrazide, N' -(1,3-dimethylbutylidene)-p-toluenesulfonohydrazide, N' -benzylidene-p-toluenesulfonohydrazide, N' -(1-phenylethylidene)-p-toluenesulfonohydrazide, N' -(2-hydroxybenzylidene)-p-toluenesulfonohydrazide, N' -diphenylmethylen-p-toluenesulfonohydrazide or N' -(2-furylmethylene)-p-toluenesulfonohydrazide.

(10) The rubber composition as described in any of the above items (1) to (9), prepared by further compounding 0.1 to 5.0 parts by weight of at least one selected from antioxidants of naphthylamine base, p-phenylenediamine base, hydroquinone derivative, bisphenol base, trisphenol base, polyphenol base, diphenylamine base, quinoline base, monophenol base, thiobisphenol base and hindered phenol base.

(11) A pneumatic tire characterized by using a rubber composition prepared by compounding 0.05 to 5 parts by weight of at least one selected from the group consisting of the hydrazide compounds represented by Formulas (I) to (IV) described above per 100 parts by weight of a rubber component comprising natural rubber and diene based rubber as principal components.

(12) The pneumatic tire as described in the above item (11), wherein the rubber composition prepared by compounding 0.05 to 5 parts by weight of at least one selected from the group consisting of the hydrazide compounds represented by Formulas (I) to (IV) described above per 100 parts by weight of the rubber component comprising natural rubber and diene based rubber as principal components is used for a tire tread part.

(13) The pneumatic tire as described in the above item (12), wherein the rubber composition prepared by compounding 0.05 to 5 parts by weight of at least one selected from the group consisting of the hydrazide compounds represented by Formula (II) described above per 100 parts by weight of the rubber component comprising natural rubber and diene based rubber as principal components is used for a tire tread part.

(14) The pneumatic tire as described in the above item (13), wherein the hydrazide compound represented by Formula (II) described above is N' -(1-methylethylidene)salicylohydrazide, N' -(1-methylpropylidene)salicylohydrazide, N' -(1,3-dimethylbutylidene)salicylohydrazide, N' -(2-furylmethylene)salicylohydrazide, 1-hydroxy- N' -(1-methylethylidene)salicylohydrazide, 1-hydroxy- N' -(1-methylpropylidene)salicylohydrazide, 1-hydroxy- N' -(1,3-dimethylbutylidene)salicylohydrazide or 1-hydroxy- N' -(2-furylmethylene)salicylohydrazide.

dene)-2-naphthohydrazide, 1-hydroxy-N'-(1-methylpropylidene)-2-naphthohydrazide, 1-hydroxy-N'-(1,3-dimethylbutylidene)-2-naphthohydrazide, 1-hydroxy-N'-(2-furylmethylene)-2-naphthohydrazide, 3-hydroxy-N'-(1-methylethylidene)-2-naphthohydrazide, 3-hydroxy-N'-(1-methylpropylidene)-2-naphthohydrazide, 3-hydroxy-N'-(1,3-dimethylbutylidene)-2-naphthohydrazide or 3-hydroxy-N'-(2-furylmethylene)-2-naphthohydrazide.

(15) The pneumatic tire as described in the above item (12), wherein 30 to 70 parts by weight of carbon black having a specific surface area by nitrogen adsorption (N_2SA) of 30 to 180 m^2/g and a dibutyl phthalate absorption (DBP) of 60 to 200 ml/100 g is compounded per 100 parts by weight of the rubber component comprising natural rubber and diene based rubber as principal components; and the hydrazide compound is one in which A in Formula (I) described above is an aromatic group.

(16) The pneumatic tire as described in the above item (13), wherein 30 to 70 parts by weight of carbon black having a specific surface area by nitrogen adsorption (N_2SA) of 30 to 180 m^2/g and a dibutyl phthalate absorption (DBP) of 60 to 200 ml/100 g is compounded per 100 parts by weight of the rubber component comprising natural rubber and diene based rubber as principal components; and Y in Formula (II) described above is an aromatic group substituted with a hydroxyl group or an amino group.

(17) A hydrazone derivative represented by Formula (V):



wherein Z represents 3-hydroxy-2-naphthyl, 1-hydroxy-2-naphthyl, 2-hydroxyphenyl or 2,6-dihydroxyphenyl group.

Brief Description of the Drawings

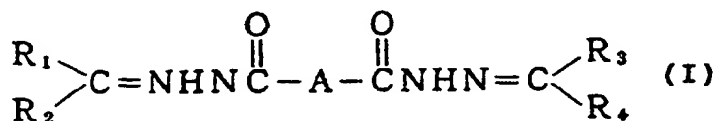
[0015]

Fig. 1 shows a partial longitudinal cross section showing one example of a pneumatic tire, and A shows a tread part which is the characteristic of the present invention.

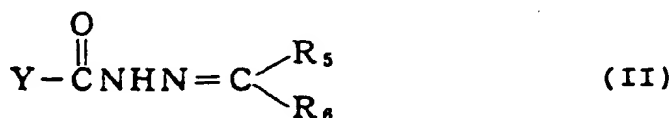
Best Mode for Carrying Out the Invention

[0016] A mode for carrying out the present invention shall be explained below in detail.

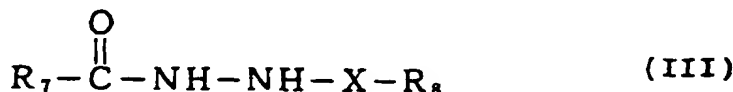
[0017] The rubber composition of the present invention is prepared by compounding 0.05 to 20 parts by weight of at least one selected from the group consisting of hydrazide compounds represented by the following Formulas (I) to (IV) per 100 parts by weight of a rubber component comprising at least one rubber selected from the group consisting of natural rubber and synthetic rubber:



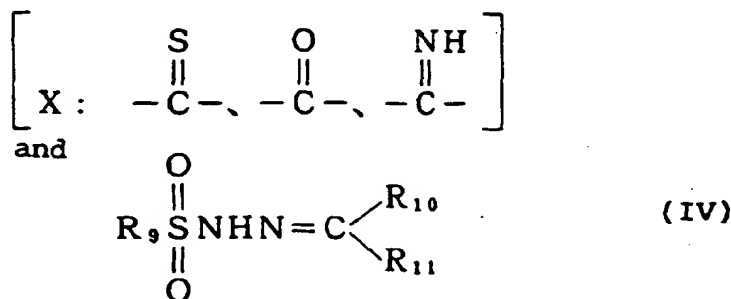
wherein A represents one selected from the group consisting of an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, a hydantoin ring which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, and a saturated or unsaturated linear hydrocarbon having 1 to 18 carbon atoms; R_1 to R_4 each represent hydrogen, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group or an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, and each of R_1 to R_4 may be the same or different, and when R_1 and R_2 and/or R_3 and R_4 are alkyl groups, R_1 may be bonded to R_2 and R_3 may be bonded to R_4 to form rings;



wherein Y represents hydrogen, an amino group, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group, an alkenyl group, an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, a pyridyl group or hydrazino group; R_5 and R_6 each represent hydrogen, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group, an alkenyl group or an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, and each of R_5 and R_6 may be the same or different, and when R_5 and R_6 are alkyl groups, R_5 may be bonded to R_6 to form a ring;



wherein R_7 and R_8 each represent an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group, an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, an alkenyl group, an amino group or an alkylamino group and each of R_7 and R_8 may be the same or different; and X represents a single bond or any of the groups represented by the following groups;



wherein R_9 represents hydrogen, an alkoxy group, an amino group, a substituted amino group, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group, an alkenyl group or an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms; and R_{10} and R_{11} each represent hydrogen, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group, an alkenyl group or an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, and each of R_{10} and R_{11} may be the same or different, and when R_{10} and R_{11} are alkyl groups, R_{10} may be bonded to R_{11} to form a ring.

[0018] With respect to a mechanism of an aging-resistant action of a hydrazide compound, it is considered that >NH contained in the structure of the hydrazide compound as is the case with conventional diphenyldiamine based antioxidants provides peroxy radicals produced in an auto-oxidation process of rubber with protons to stabilize, whereby an aging-resistant action is shown.

[0019] The hydrazide compounds used in the present invention consisting of the compound groups represented by Formulas (I) to (IV) described above are prepared by modifying a hydrazide group, which accelerates vulcanization reaction, with ketone, aldehyde and sulfonic acid, and it is presumed that these modified hydrazide compounds restrain reaction of rubber with a vulcanization-accelerating agent and sulfur while maintaining an effect as an antioxidant, so that the aging-resistant effect can be compatible with the workability (this matter shall be explained in further detail with reference to examples described later).

[0020] Further, among the compounds used in the present invention represented by Formulas (I) and (II) described above, the hydrazide compounds in which respective A and Y are an aromatic group having substituents have an action to control an increase in the viscosity as well as an aging-resistant effect while maintaining a low heat generation property effect of rubber. The action mechanism thereof resides in reducing the reactivity of the hydrazide group with a rubber polymer by modifying the hydrazide group as mentioned above. In addition, the hydrazide compounds have a function to maintain and enhance the reactivity of rubber with carbon black.

[0021] A of the compound (I) used in the present invention includes an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, a hydantoin ring which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitro-

gen atoms, and a saturated or unsaturated linear hydrocarbon having 1 to 18 carbon atoms such as ethylene, tetramethylene, heptamethylene, octamethylene, octadecamethylene and 7,11-octadecadienylene group.

[0022] Further, R_1 to R_4 each represent hydrogen, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group or an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, and each of R_1 to R_4 may be the same or different, and when R_1 and R_2 and/or R_3 and R_4 are alkyl groups, R_1 may be bonded to R_2 and R_3 may be bonded to R_4 to form rings.

[0023] The specific compounds represented by Formula (I) described above include N^2,N^4 -di(1-methylethylidene)isophthalodihydrazide, N^2,N^4 -di(1-methylethylidene)adipodihydrazide, N^2,N^4 -di(1-methylpropylidene)isophthalodihydrazide, N^2,N^4 -di(1-methylpropylidene)adipodihydrazide, N^2,N^4 -di(1-methylbutylidene)isophthalodihydrazide, N^2,N^4 -di(1-methylbutylidene)adipodihydrazide, N^2,N^4 -di(1,3-dimethylbutylidene)isophthalodihydrazide, N^2,N^4 -di(1,3-dimethylbutylidene)adipodihydrazide, N^2,N^4 -di(1-phenylethylidene)isophthalodihydrazide and N^2,N^4 -di(1-phenylethylidene)adipodihydrazide, which are the derivatives of isophthalodihydrazide and adipodihydrazide. In addition to these derivatives of isophthalodihydrazide and adipodihydrazide, the derivatives of the following dihydrazide compounds provide the similar effect.

[0024] They include, for example, the derivatives of terephthalodihydrazide, azelaodihydrazide, succinodihydrazide and icosanodicarboxylic dihydrazide.

[0025] Among them, the derivatives of isophthalodihydrazide such as N^2,N^4 -di(1-methylethylidene)isophthalodihydrazide, N^2,N^4 -di(1-methylpropylidene)isophthalodihydrazide and N^2,N^4 -di(1,3-dimethylbutylidene)isophthalodihydrazide which provide an aging-resistant effect and a good low heat generation property effect and markedly inhibit an increase in the Mooney viscosity value provide the largest effect with respect to the present invention and can reduce the Mooney viscosity while maintaining the low heat generation property.

[0026] Specific hydrazide compounds used in the present invention consisting of the compound group represented by Formula (II) described above include the following compounds.

[0027] The compounds in which Y is an aromatic group include:

N' -(1-methylethylidene)benzohydrazide,
 N' -(1-methylpropylidene)benzohydrazide,
 N' -(1,3-dimethylbutylidene)benzohydrazide,
 N' -benzylidenebenzohydrazide,
 N' -(4-dimethylaminobenzylidene)benzohydrazide,
 N' -(4-methoxybenzylidene)benzohydrazide,
 N' -(2-hydroxybenzylidene)benzohydrazide,
 N' -(4-hydroxybenzylidene)benzohydrazide,
 N' -diphenylethylidenebenzohydrazide,
 N' -(1-phenylmethylene)benzohydrazide,
 N' -(α -(2,4-dihydroxyphenyl)benzylidene)benzohydrazide,
 N' -(2-furylmethylene)benzohydrazide,
 N' -(1-methylethylidene)salicylohydrazide,
 N' -(1-methylpropylidene)salicylohydrazide,
 N' -(1-methylbutylidene)salicylohydrazide,
 N' -(1,3-dimethylbutylidene)salicylohydrazide,
 N' -(2-furylmethylene)salicylohydrazide,
2,6-dihydroxy- N' -(1,3-dimethylbutylidene)benzohydrazide,
 N' -(1-methylethylidene)-1-naphthohydrazide,
 N' -(1-methylpropylidene)-1-naphthohydrazide,
 N' -(1,3-dimethylbutylidene)-1-naphthohydrazide,
 N' -benzylidene-1-naphthohydrazide,
 N' -(4-dimethylaminobenzylidene)-1-naphthohydrazide,
 N' -(4-methoxybenzylidene)-1-naphthohydrazide,
 N' -(4-hydroxybenzylidene)-1-naphthohydrazide,
 N' -(1-phenylethylidene)-1-naphthohydrazide,
 N' -diphenylmethylene-1-naphthohydrazide,
 N' -(α -(2,4-dihydroxyphenyl)benzylidene)-1-naphthohydrazide,
 N' -(2-furylmethylene)-1-naphthohydrazide,
 N' -(1-methylethylidene)-2-naphthohydrazide,
 N' -(1-methylpropylidene)-2-naphthohydrazide,
 N' -(1,3-dimethylbutylidene)-2-naphthohydrazide,
 N' -benzylidene-2-naphthohydrazide,

N'-(4-dimethylaminobenzylidene)-2-naphthohydrazide,
 N'-(4-methoxybenzylidene)-2-naphthohydrazide,
 N'-(2-hydroxybenzylidene)-2-naphthohydrazide,
 N'-(4-hydroxybenzylidene)-2-naphthohydrazide,
 5 N'-(1-phenylethylidene)-2-naphthohydrazide,
 N'-diphenylmethylene-2-naphthohydrazide,
 N'-(α -(2,4-dihydroxyphenyl)benzylidene)-2-naphthohydrazide,
 1-hydroxy-N'-(1-methylethylidene)-2-naphthohydrazide,
 1-hydroxy-N'-(1-methylpropylidene)-2-naphthohydrazide,
 10 1-hydroxy-N'-(1-methylbutylidene)-2-naphthohydrazide,
 1-hydroxy-N'-(1,3-dimethylbutylidene)-2-naphthohydrazide,
 1-hydroxy-N'-(2-furylmethylene)-2-naphthohydrazide,
 3-hydroxy-N'-(1-methylethylidene)-2-naphthohydrazide,
 3-hydroxy-N'-(1-methylpropylidene)-2-naphthohydrazide,
 15 3-hydroxy-N'-(1-methylbutylidene)-2-naphthohydrazide,
 3-hydroxy-N'-(1,3-dimethylbutylidene)-2-naphthohydrazide,
 3-hydroxy-N'-(1-phenylethylidene)-2-naphthohydrazide, and
 3-hydroxy-N'-(2-furylmethylene)-2-naphthohydrazide,

20 as well as 4-hydroxybenzohydrazide and anthranilohydrazide. These N'-(1,3-dimethylbutylidene)salicylohydrazide, 1-hydroxy-N'-(1,3-dimethylbutylidene)-2-naphthohydrazide, 2,6-dihydroxy-N'-(1,3-dimethylbutylidene)benzohydrazide and 3-hydroxy-N'-(1,3-dimethylbutylidene)-2-naphthohydrazide are novel substances.

[0028] The compounds in which Y is an alkyl group include:

25 N'-(1-methylethylidene)propionohydrazide
 N'-(1-methylpropylidene)propionohydrazide,
 N'-(1,3-dimethylbutylidene)propionohydrazide,
 N'-benzylidenepropionohydrazide,
 N'-(4-dimethylaminobenzylidene)propionohydrazide,
 30 N'-(4-methoxybenzylidene)propionohydrazide,
 N'-(2-hydroxybenzylidene)propionohydrazide,
 N'-(4-hydroxybenzylidene)propionohydrazide,
 N'-(1-phenylethylidene)propionohydrazide,
 N'-diphenylmethylenepropionohydrazide,
 35 N'-(α -(2,4-dihydroxyphenyl)benzylidene)propionohydrazide,
 N'-(2-furylmethylene)propionohydrazide,
 N'-(1-methylethylidene)-2-methylpropionohydrazide,
 N'-(1-methylpropylidene)-2-methylpropionohydrazide,
 N'-(1,3-dimethylbutylidene)-2-methylpropionohydrazide,
 40 N'-benzylidene-2-methylpropionohydrazide,
 N'-(4-dimethylaminobenzylidene)-2-methylpropionohydrazide,
 N'-(4-methoxybenzylidene)-2-methylpropionohydrazide,
 N'-(4-hydroxybenzylidene)-2-methylpropionohydrazide,
 N'-(1-phenylethylidene)-2-methylpropionohydrazide,
 45 N'-diphenylmethylene-2-methylpropionohydrazide,
 N'-(α -(2,4-dihydroxyphenyl)benzylidene)-2-methylpropionohydrazide,
 N'-(2-furylmethylene)-2-methylpropionohydrazide,
 N'-(1-methylethylidene)-2,2'-dimethylpropionohydrazide,
 N'-(1-methylpropylidene)-2,2'-dimethylpropionohydrazide,
 50 N'-(1,3-dimethylbutylidene)-2,2'-dimethylpropionohydrazide,
 N'-benzylidene-2,2'-dimethylpropionohydrazide,
 N'-(4-dimethylaminobenzylidene)-2,2'-dimethylpropionohydrazide,
 N'-(4-methoxybenzylidene)-2,2'-dimethylpropionohydrazide,
 N'-(4-hydroxybenzylidene)-2,2'-dimethylpropionohydrazide,
 55 N'-(1-phenylethylidene)-2,2'-dimethylpropionohydrazide,
 N'-diphenylmethylene-2,2'-dimethylpropionohydrazide,
 N'-(α -(2,4-dihydroxyphenyl)benzylidene)-2,2'-dimethylpropionohydrazide,
 N'-(2-furylmethylene)-2,2'-dimethylpropionohydrazide,

N'-(1-methylethylidene)octanohydrazide,
 N'-(1-methylpropylidene)octanohydrazide,
 N'-(1,3-dimethylbutylidene)octanohydrazide,
 N'-benzylideneoctanohydrazide,
 5 N'-(4-dimethylaminobenzylidene)octanohydrazide,
 N'-(4-methoxybenzylidene)octanohydrazide,
 N'-(4-hydroxybenzylidene)octanohydrazide,
 N'-(1-phenylethylidene)octanohydrazide,
 N'-diphenylmethyleneoctanohydrazide,
 10 N'-(α -(2,4-dihydroxyphenyl)benzylidene)octanohydrazide,
 N'-(2-furylmethylene)octanohydrazide,
 N'-(1-methylethylidene)stearohydrazide,
 N'-(1-methylpropylidene)stearohydrazide,
 N'-(1,3-dimethylbutylidene)stearohydrazide,
 15 N'-benzylidenestearohydrazide,
 N'-(4-dimethylaminobenzylidene)stearohydrazide,
 N'-(4-methoxybenzylidene)stearohydrazide,
 N'-(2-hydroxybenzylidene)stearohydrazide,
 N'-(4-hydroxybenzylidene)stearohydrazide,
 20 N'-(1-phenylethylidene)stearohydrazide,
 N'-diphenylmethylenestearohydrazide,
 N'-(α -(2,4-dihydroxyphenyl)benzylidene)stearohydrazide,
 N'-(2-furylmethylene)stearohydrazide.

25 **[0029]** The compounds in which Y is a pyridyl group or a hydrazino group include the derivatives of isonicotinohydrazide such as N'-(1-methylethylidene)isonicotinohydrazide, N'-(1-methylpropylidene)isonicotinohydrazide, N'-(1,3-dimethylbutylidene)isonicotinohydrazide and N'-(1-phenylethylidene)isonicotinohydrazide, as well as the derivatives of carbohydrazide.

30 **[0030]** Among these hydrazide compounds, the following compounds are preferred since they have an aging-resistant effect as well as a low heat generation property:

N'-(1-methylethylidene)salicylohydrazide,
 N'-(1-methylpropylidene)salicylohydrazide,
 N'-(1,3-dimethylbutylidene)salicylohydrazide,
 35 N'-(2-furylmethylene)salicylohydrazide,
 1-hydroxy-N'-(1-methylethylidene)-2-naphthohydrazide,
 1-hydroxy-N'-(1-methylpropylidene)-2-naphthohydrazide,
 1-hydroxy-N'-(1,3-dimethylbutylidene)-2-naphthohydrazide,
 3-hydroxy-N'-(2-furylmethylene)-2-naphthohydrazide,
 40 3-hydroxy-N'-(1-methylethylidene)-2-naphthohydrazide,
 3-hydroxy-N'-(1-methylpropylidene)-2-naphthohydrazide,
 3-hydroxy-N'-(1,3-dimethylbutylidene)-2-naphthohydrazide and
 3-hydroxy-N'-(2-furylmethylene)-2-naphthohydrazide,

45 **[0031]** Synthetic methods of the hydrazide compounds represented by Formulas (I) and (II) described above are described in the literature : Pant, U. C.; Ramchandran, Reena; Joshi, B. C., Rev. Roum. Chim. (1979) 24 (3), 471-82, and they can easily be synthesized by reacting compounds having hydrazide with prescribed aldehyde and ketone. The specific synthetic examples shall further be explained in the section of the examples.

50 **[0032]** The hydrazide compounds represented by Formula (III) described above include, for example, N-benzoyl-N'-methylhydrazine, N-benzoyl-N'-ethylhydrazine, N-benzoyl-N'-n-butylhydrazine, N-benzoyl-N'-isobutylhydrazine, N-benzoyl-N'-t-butylhydrazine, N-benzoyl-N'-stearylhydrazine, N-benzoyl-N'-cyclohexylhydrazine, N-benzoyl-N'-phenylhydrazine, N-benzoyl-N'- α -naphthylhydrazine, N-benzoyl-N'- β -naphthylhydrazine, N-ethyl-N'-salicyloylhydrazine, N-n-butyl-N'-salicyloylhydrazine, N-isobutyl-N'-salicyloylhydrazine, N-t-butyl-N'-salicyloylhydrazine, N-stearyl-N'-salicyloylhydrazine, N-cyclohexyl-N'-salicyloylhydrazine, N-phenyl-N'-salicyloylhydrazine, N- α -naphthyl-N'-salicyloylhydrazine, N- β -naphthyl-N'-salicyloylhydrazine, N-ethyl-N'- α -naphthoylhydrazine, N-n-butyl-N'- α -naphthoylhydrazine, N-isobutyl-N'- α -naphthoylhydrazine, N-t-butyl-N'- α -naphthoylhydrazine, N-stearyl-N'- α -naphthoylhydrazine, N-cyclohexyl-N'- α -naphthoylhydrazine, N-phenyl-N'- α -naphthoylhydrazine, N- α -naphthoyl-N'- α -naphthoylhydrazine, N- α -naphthoyl-N'- β -naphthoylhydrazine, N-ethyl-N'- β -naphthoylhydrazine, N-n-butyl-N'- β -naphthoylhydrazine, N-isobutyl-N'- β -

naphthoylhydrazine, N-t-butyl-N'- β -naphthoylhydrazine, N-stearyl-N'- β -naphthoylhydrazine, N-cyclohexyl-N'- β -naphthoylhydrazine, N-phenyl-N'- β -naphthoylhydrazine, N- α -naphthyl-N'- β -naphthoylhydrazine, N- β -naphthyl-N'- β -naphthoylhydrazine, N-ethyl-N'-valerylhydrazine, N-n-butyl-N'-valerylhydrazine, N-isobutyl-N'-valerylhydrazine, N-t-butyl-N'-valerylhydrazine, N-stearyl-N'-valerylhydrazine, N-cyclohexyl-N'-valerylhydrazine, N-phenyl-N'-valerylhydrazine, N- α -naphthyl-N'-valerylhydrazine, N- β -naphthyl-N'-valerylhydrazine, N-ethyl-N'-isovalerylhydrazine, N-n-butyl-N'-isovalerylhydrazine, N-isobutyl-N'-isovalerylhydrazine, N-t-butyl-N'-isovalerylhydrazine, N-isovaleryl-N'-stearylhydrazine, N-cyclohexyl-N'-isovalerylhydrazine, N-isovaleryl-N'-phenylhydrazine, N-isovaleryl-N'- α -naphthylhydrazine, N-isovaleryl-N'- β -naphthylhydrazine, N-ethyl-N'-pivaloylhydrazine, N-n-butyl-N'-pivaloylhydrazine, N-isobutyl-N'-pivaloylhydrazine, N-t-butyl-N'-pivaloylhydrazine, N-stearyl-N'-pivaloylhydrazine, N-cyclohexyl-N'-pivaloylhydrazine, N-phenyl-N'-pivaloylhydrazine, N- α -naphthyl-N'-pivaloylhydrazine, N- β -naphthyl-N'-pivaloylhydrazine, N-ethyl-N'-stearoylhydrazine, N-n-butyl-N'-stearoylhydrazine, N-isobutyl-N'-stearoylhydrazine, N-t-butyl-N'-stearoylhydrazine, N-stearyl-N'-stearoylhydrazine, N-cyclohexyl-N'-stearoylhydrazine, N-phenyl-N'-stearoylhydrazine, N- α -naphthyl-N'-stearoylhydrazine, N- β -naphthyl-N'-stearoylhydrazine, N-benzoyl-N'-butyrylhydrazine, N-benzoyl-N'-pivaloylhydrazine, N-benzoyl-N'-stearoylhydrazine, N-benzoyl-N'- α -naphthoylhydrazine, N-benzoyl-N'- β -naphthoylhydrazine, N-benzoyl-N'-salicyloylhydrazine, N,N'-dibenzoylhydrazine, 1-benzoylsemicarbazide, N-butyryl-N'-salicyloylhydrazine, N-pivaloyl-N'-salicyloylhydrazine, N-salicyloyl-N'-stearoylhydrazine, N- α -naphthoyl-N'-salicyloylhydrazine, N- β -naphthoyl-N'-salicyloylhydrazine, N,N'-disalicyloylhydrazine, 1-salicyloylsemicarbazide, N-butyryl-N'- α -naphthoylhydrazine, N- α -naphthoyl-N'-pivaloylhydrazine, N- α -naphthoyl-N'-stearoylhydrazine, N-butyryl-N'- β -naphthoylhydrazine, N- β -naphthoyl-N'-pivaloylhydrazine, N- β -naphthoyl-N'-stearoylhydrazine, N,N'-dibutyrylhydrazine, N,N'-dipivaloylhydrazine, 1-benzamidoguanidine and 1-benzoylthiosemicarbazide.

[0033] In the hydrazide compound represented by Formula (III) described above used in the present invention, R₇ in Formula (III) is preferably phenyl or naphthyl, and to be specific, the hydrazide compound is preferably N-benzoyl-N'-phenylhydrazine, 1-benzamidoguanidine or 1-benzoylsemicarbazide. In these cases, further excellent aging-resistant action shall be displayed.

[0034] These hydrazide compounds can readily be synthesized by reacting various hydrazide compounds with benzoyl chloride and the like in the presence of sodium acetate in an acetic acid solution. The specific synthetic methods thereof shall further be explained in the section of the examples.

[0035] The sulfonohydrazide compounds represented by Formula (IV) used in the present invention include the following compounds:

N'-(1-methylethylidene)benzenesulfonohydrazide,
 N'-(1-methylpropylidene)benzenesulfonohydrazide,
 N'-(1,3-dimethylbutylidene)benzenesulfonohydrazide,
 N'-benzylidenebenzenesulfonohydrazide,
 N'-(4-dimethylaminobenzylidene)benzenesulfonohydrazide,
 N'-(4-methoxybenzylidene)benzenesulfonohydrazide,
 N'-(2-hydroxybenzylidene)benzenesulfonohydrazide,
 N'-(4-hydroxybenzylidene)benzenesulfonohydrazide,
 N'-(1-phenylethylidene)benzenesulfonohydrazide,
 N'-diphenylmethylenbenzenesulfonohydrazide,
 N'-(α -(2,4-dihydroxyphenyl)benzylidene)benzenesulfonohydrazide,
 N'-(2-furylmethylene)benzenesulfonohydrazide,
 N'-(1-methylethylidene)-p-toluenesulfonohydrazide,
 N'-(1-methylpropylidene)-p-toluenesulfonohydrazide,
 N'-(1,3-dimethylbutylidene)-p-toluenesulfonohydrazide,
 N'-benzylidene-p-toluenesulfonohydrazide,
 N'-(4-dimethylaminobenzylidene)-p-toluenesulfonohydrazide,
 N'-(4-methoxybenzylidene)-p-toluenesulfonohydrazide,
 N'-(2-hydroxybenzylidene)-p-toluenesulfonohydrazide,
 N'-(4-hydroxybenzylidene)-p-toluenesulfonohydrazide,
 N'-(1-phenylethylidene)-p-toluenesulfonohydrazide,
 N'-diphenylmethylene-p-toluenesulfonohydrazide,
 N'-(α -(2,4-dihydroxyphenyl)benzylidene)-p-toluenesulfonohydrazide,
 N'-(2-furylmethylene)-p-toluenesulfonohydrazide,
 N'-(1-methylethylidene)-1-naphthalenesulfonohydrazide,
 N'-(1-methylpropylidene)-1-naphthalenesulfonohydrazide,
 N'-(1,3-dimethylbutylidene)-1-naphthalenesulfonohydrazide,
 N'-benzylidene-1-naphthalenesulfonohydrazide,

N'-(4-dimethylaminobenzylidene)-1-naphthalenesulfonohydrazide,
 N'-(4-methoxybenzylidene)-1-naphthalenesulfonohydrazide,
 N'-(2-hydroxybenzylidene)-1-naphthalenesulfonohydrazide,
 N'-(4-hydroxybenzylidene)-1-naphthalenesulfonohydrazide,
 5 N'-(1-phenylethylidene)-1-naphthalenesulfonohydrazide,
 N'-diphenylmethylene-1-naphthalenesulfonohydrazide,
 N'-(α -(2,4-dihydroxyphenyl)benzylidene)-1-naphthalenesulfonohydrazide,
 N'-(2-furylmethylene)-1-naphthalenesulfonohydrazide,
 N'-(1-methylethylidene)-2-naphthalenesulfonohydrazide,
 10 N'-(1-methylpropylidene)-2-naphthalenesulfonohydrazide,
 N'-(1,3-dimethylbutylidene)-2-naphthalenesulfonohydrazide,
 N'-benzylidene-2-naphthalenesulfonohydrazide,
 N'-(4-dimethylaminobenzylidene)-2-naphthalenesulfonohydrazide,
 N'-(4-methoxybenzylidene)-2-naphthalenesulfonohydrazide,
 15 N'-(2-hydroxybenzylidene)-2-naphthalenesulfonohydrazide,
 N'-(4-hydroxybenzylidene)-2-naphthalenesulfonohydrazide,
 N'-(1-phenylethylidene)-2-naphthalenesulfonohydrazide,
 N'-diphenylmethylene-2-naphthalenesulfonohydrazide,
 N'-(α -(2,4-dihydroxyphenyl)benzylidene)-2-naphthalenesulfonohydrazide,
 20 N'-(2-furylmethylene)-2-naphthalenesulfonohydrazide,
 N'-(1-methylethylidene)propanesulfonohydrazide,
 N'-(1-methylpropylidene)propanesulfonohydrazide,
 N'-(1,3-dimethylbutylidene)propanesulfonohydrazide,
 N'-benzylidenepropanesulfonohydrazide,
 25 N'-(4-dimethylaminobenzylidene)propanesulfonohydrazide,
 N'-(4-methoxybenzylidene)propanesulfonohydrazide,
 N'-(2-hydroxybenzylidene)propanesulfonohydrazide,
 N'-(4-hydroxybenzylidene)propanesulfonohydrazide,
 N'-(1-phenylethylidene)propanesulfonohydrazide,
 30 N'-diphenylmethylenepropanesulfonohydrazide,
 N'-(α -(2,4-dihydroxyphenyl)benzylidene)propanesulfonohydrazide,
 N'-(2-furylmethylene)propanesulfonohydrazide,
 N'-(1-methylethylidene)isopropylsulfonohydrazide,
 N'-(1-methylpropylidene)isopropylsulfonohydrazide,
 35 N'-(1,3-dimethylbutylidene)isopropylsulfonohydrazide,
 N'-benzylideneisopropylsulfonohydrazide,
 N'-(4-dimethylaminobenzylidene)isopropylsulfonohydrazide,
 N'-(4-methoxybenzylidene)isopropylsulfonohydrazide,
 N'-(2-hydroxybenzylidene)isopropylsulfonohydrazide,
 40 N'-(4-hydroxybenzylidene)isopropylsulfonohydrazide,
 N'-(1-phenylethylidene)isopropylsulfonohydrazide,
 N'-diphenylmethylenesisopropylsulfonohydrazide,
 N'-(α -(2,4-dihydroxyphenyl)benzylidene)isopropylsulfonohydrazide,
 N'-(2-furylmethylene)isopropylsulfonohydrazide,
 45 N'-(1-methylethylidene)methanesulfonohydrazide,
 N'-(1-methylpropylidene)methanesulfonohydrazide,
 N'-(1,3-dimethylbutylidene)methanesulfonohydrazide,
 N'-benzylidenemethanesulfonohydrazide,
 N'-(4-dimethylaminobenzylidene)methanesulfonohydrazide,
 50 N'-(4-methoxybenzylidene)methanesulfonohydrazide,
 N'-(2-hydroxybenzylidene)methanesulfonohydrazide,
 N'-(4-hydroxybenzylidene)methanesulfonohydrazide,
 N'-(1-phenylethylidene)methanesulfonohydrazide,
 N'-diphenylmethylenemethanesulfonohydrazide,
 55 N'-(α -(2,4-dihydroxyphenyl)benzylidene)methanesulfonohydrazide,
 N'-(2-furylmethylene)methanesulfonohydrazide,
 N'-(1-methylethylidene)dodecanesulfonohydrazide,
 N'-(1-methylpropylidene)dodecanesulfonohydrazide,

N'-(1,3-dimethylbutylidene)dodecanesulfonohydrazide,
 N'-benzylidenedodecanesulfonohydrazide,
 N'-(4-dimethylaminobenzylidene)dodecanesulfonohydrazide,
 N'-(4-methoxybenzylidene)dodecanesulfonohydrazide,
 5 N'-(2-hydroxybenzylidene)dodecanesulfonohydrazide,
 N'-(4-hydroxybenzylidene)dodecanesulfonohydrazide,
 N'-(1-phenylethylidene)dodecanesulfonohydrazide,
 N'-diphenylmethylenedodecanesulfonohydrazide,
 N'-(α -(2,4-dihydroxyphenyl)benzylidene)dodecanesulfonohydrazide,
 10 N'-(2-furylmethylene)dodecanesulfonohydrazide,
 N'-(1-methylethylidene)-p-dodecylbenzenesulfonohydrazide,
 N'-(1-methylpropylidene)-p-dodecylbenzenesulfonohydrazide,
 N'-(1,3-dimethylbutylidene)-p-dodecylbenzenesulfonohydrazide,
 N'-benzylidene-p-dodecylbenzenesulfonohydrazide,
 15 N'-(4-dimethylaminobenzylidene)-p-dodecylbenzenesulfonohydrazide,
 N'-(4-methoxybenzylidene)-p-dodecylbenzenesulfonohydrazide,
 N'-(2-hydroxybenzylidene)-p-dodecylbenzenesulfonohydrazide,
 N'-(4-hydroxybenzylidene)-p-dodecylbenzenesulfonohydrazide,
 N'-(1-phenylethylidene)-p-dodecylbenzenesulfonohydrazide,
 20 N'-diphenylmethylene-p-dodecylbenzenesulfonohydrazide,
 N'-(α -(2,4-dihydroxyphenyl)benzylidene)-p-dodecylbenzenesulfonohydrazide,
 N'-(2-furylmethylene)-p-dodecylbenzenesulfonohydrazide,
 N'-(1-methylethylidene)-4-acetamidobenzenesulfonohydrazide,
 N'-(1-methylpropylidene)-4-acetamidobenzenesulfonohydrazide,
 25 N'-(1,3-dimethylbutylidene)-4-acetamidobenzenesulfonohydrazide,
 N'-benzylidene-4-acetamidobenzenesulfonohydrazide,
 N'-(4-dimethylaminobenzylidene)-4-acetamidobenzenesulfonohydrazide,
 N'-(4-methoxybenzylidene)-4-acetamidobenzenesulfonohydrazide,
 N'-(2-hydroxybenzylidene)-4-acetamidobenzenesulfonohydrazide,
 30 N'-(4-hydroxybenzylidene)-4-acetamidobenzenesulfonohydrazide,
 N'-(1-phenylethylidene)-4-acetamidobenzenesulfonohydrazide,
 N'-diphenylmethylene-4-acetamidobenzenesulfonohydrazide,
 N'-(α -(2,4-dihydroxyphenyl)benzylidene)-4-acetamidobenzenesulfonohydrazide,
 N'-(2-furylmethylene)-4-acetamidobenzenesulfonohydrazide,

35 [0036] Among these various sulfonohydrazide compounds, preferred in terms of an aging-resistant effect, a raw material cost and ease in synthesis are N'-(1-methylethylidene)benzenesulfonohydrazide, N'-(1-methylpropylidene)benzenesulfonohydrazide, N'-(1,3-dimethylbutylidene)benzenesulfonohydrazide, N'-(1-phenylethylidene)benzenesulfonohydrazide, N'-(2-hydroxybenzylidene)benzenesulfonohydrazide, N'-diphenylmethylenebenzenesulfonohydrazide, N'-(2-furylmethylene)benzenesulfonohydrazide, N'-(1-methylethylidene)-p-toluenesulfonohydrazide, N'-(1-methylpropylidene)-p-toluenesulfonohydrazide, N'-(1,3-dimethylbutylidene)-p-toluenesulfonohydrazide, N'-(2-hydroxybenzylidene)-p-toluenesulfonohydrazide, N'-(1-phenylethylidene)-p-toluenesulfonohydrazide, N'-diphenylmethylene-p-toluenesulfonohydrazide and N'-(2-furylmethylene)-p-toluenesulfonohydrazide.

45 [0037] The sulfonohydrazide compounds represented by Formula (IV) described above are so good as to provide a hardening inhibition effect which has not been able to be achieved by conventional antioxidants and display particularly an excellent action against breaking properties after aging.

[0038] In the hardening inhibition effect described above, it is inferred that the specific sulfonohydrazide compounds described above selectively inhibit an increase in cross-linking which is particularly most related to hardening of rubber among various aging reactions.

50 [0039] These various sulfonohydrazide compounds can easily be synthesized by reacting compounds having hydrazide groups with prescribed ketone and aldehyde compounds or reacting hydrazide compounds with sulfonic acid chloride. The specific synthetic examples shall further be explained in the section of the examples.

[0040] The various hydrazide compounds represented by Formulas (I) to (IV) described above can be used alone or in combination of two or more kinds thereof. They are used in a range of 0.05 to 20 parts by weight, preferably 0.1 to 5.0 parts by weight per 100 parts by weight of the rubber component.

[0041] The amount of less than 0.05 part by weight of the aforementioned hydrazide compounds does not display the intended effect of the present invention, and the amount exceeding 20 parts by weight results in not only almost satu-

rating the effect but also reducing the other physical properties and thus is not economical. Accordingly, both are not preferred.

[0042] The various hydrazone compounds represented by Formulas (I) to (IV) described above used in the present invention are effective as antioxidants even if they are used alone, but if they are used in combination with antioxidants usually used in the rubber industry, further higher aging-resistant effect can be obtained.

[0043] It has so far been known that when two or more kinds of antioxidants are used in combination, a synergetic effect is shown depending on the combination of the antioxidants used, and it is widely known that the kinds of these synergetic effects include homosynergism which takes place when two or more kinds of the antioxidants of a peroxy radical acceptor type are used in combination and heterosynergism which takes place when antioxidants having different action mechanisms are used in combination as is the case with, for example, the combination of the antioxidants of a peroxy radical acceptor type and the antioxidants of a peroxide decomposer type.

[0044] In the present invention, the various hydrazone compounds described above are the antioxidants of a peroxy radical acceptor type, and when they are used in combination with conventional other diphenylamine based and hindered phenol based antioxidants of a peroxy radical acceptor type, the former homosynergism is shown, and as a result, displayed is a specific effect such that the combined use of the hydrazone compounds provides more effect in a smaller amount than the single use of the existing diphenylamine based and hindered phenol based antioxidants does in a large amount.

[0045] If this hydrazone compound is compounded, the elastic modulus before and after degradation is less reduced than when a diphenyldiamine based antioxidant is compounded.

[0046] Antioxidants used in combination include, for example, naphthylamine base, p-phenylenediamine base, hydroquinone derivatives, bisphenol base, trisphenol base, polyphenol base, diphenylamine base, quinoline base, monophenol base, thiobisphenol base and hindered phenol base. Among them, amine based antioxidants of p-phenylenediamine base and diphenylamine base are preferred in terms of further higher aging-resistant effect.

[0047] The diphenylamine based antioxidants include, for example, 4,4'-(α -methylbenzyl)diphenylamine, 4,4'-(α , α -dimethylbenzyl)diphenylamine, p-(p-toluenesulfonylamido)diphenylamine and 4,4'-dioctyldiphenylamine. Among them, 4,4'-(α -methylbenzyl)diphenylamine is most preferred in terms of further higher aging-resistant effect.

[0048] The p-phenylenediamine based antioxidants include, for example, N,N'-diphenyl-p-phenylenediamine, N-isopropyl-N'-phenyl-p-phenylenediamine, N,N'-di-2-naphthyl-p-phenylenediamine, N-cyclohexyl-N'-phenyl-p-phenylenediamine, N-phenyl-N'-(3-methacryloyloxy-2-hydroxypropyl)-p-phenylenediamine, N,N'-bis(1-methylheptyl)-p-phenylenediamine, N,N'-bis(1,4-dimethylpentyl)-p-phenylenediamine, N,N'-bis(1-ethyl-3-methylpentyl)-p-phenylenediamine and N-(1,3-dimethylbutyl)-N'-phenyl-p-phenylenediamine. Among them, N-(1,3-dimethylbutyl)-N'-phenyl-p-phenylenediamine is most preferred in terms of further higher aging-resistant effect and a cost.

[0049] The antioxidants used in combination with the hydrazone compounds represented by Formulas (I) to (IV) described above can be used alone or in combination of two or more kinds thereof. They are used in a range of 0.1 to 5.0 parts by weight, preferably 0.2 to 4.0 parts by weight per 100 parts by weight of the rubber component.

[0050] The rubbers used in the present invention are natural and synthetic rubbers. The synthetic rubbers include, for example, cis-1,4-polyisoprene, styrene-butadiene copolymers, low cis-1,4-polybutadiene, high cis-1,4-polybutadiene ethylene-propylene-diene copolymers, chloroprene rubber, halogenated butyl rubber and acrylonitrile-butadiene rubber, and at least one of them can be compounded. Preferred synthetic rubber is a diene based synthetic rubber.

[0051] Among these natural rubber and synthetic rubbers, natural rubber (which may be polyisoprene rubber) is used in a proportion of 30 phr, whereby a low heat generation property effect as well as an aging-resistant effect provided by the hydrazone compound can sufficiently be displayed.

[0052] Further, at least one of carbon black, silica, calcium carbonate and titanium oxide can be used as a reinforcing filler used in the present invention, and carbon black is preferred.

[0053] The compounding amount of the reinforcing filler is 20 to 150 parts by weight, preferably 25 to 80 parts by weight per 100 parts by weight of the rubber component described above. If the compounding amount of the reinforcing filler is less than 20 parts by weight, the breaking characteristic and the abrasion resistance of the vulcanized material are not sufficiently high, and the amount exceeding 150 parts by weight is not preferred in terms of the workability.

[0054] Carbon black used as the reinforcing filler includes, for example, carbon blacks such as HAF, ISAF and SAF.

[0055] The rubber composition blended with the hydrazone compounds represented by Formulas (I) to (IV) described above is used for a pneumatic tire to thereby obtain the pneumatic tire having an excellent aging-resistant characteristic.

[0056] Tire members for which the rubber composition is employed include tread, coating rubber for carcass or belt, side rubber, bead filler, rubber chaffer and inliner.

[0057] In particular, the rubber composition blended with a part of the compounds described above among the hydrazone compounds represented by Formulas (I) or (II) has an excellent low heat generation property and is used for a tire tread part, whereby a pneumatic tire having an excellent low heat generation property can be obtained. In this case, preferred are carbon blacks having the characteristics of a specific surface area by nitrogen adsorption (N_2 SA) of

30 to 180 m²/g and a dibutyl phthalate absorption (DBP) of 60 to 200 ml/100 g, more preferably a specific surface area by nitrogen adsorption of 70 to 160 m²/g and a DBP of 70 to 140 ml/100 g.

[0058] If carbon black has a N₂SA of less than 30 and a DBP of less than 60, there is a small effect on improving the heat generation property. On the other hand, if the N₂SA exceeds 180 and the DBP exceeds 200, the viscosity of non-vulcanized rubber rises to deteriorate the workability.

[0059] The compounding amount of carbon black having the characteristics described above is preferably 30 to 70 parts by weight, more preferably 35 to 60 parts by weight per 100 parts by weight of the rubber component described above.

[0060] In the present invention, the rubber composition can be blended, if necessary, with additives such as a vulcanizing agent, process oil, a vulcanization accelerator, zinc oxide (ZnO), stearic acid, an antioxidant, an antiozonant and a silane coupling agent each of which is usually used in the rubber industry as well as the rubber component, the reinforcing filler and the hydrazide compounds represented by Formulas (I) to (IV) described above.

[0061] The vulcanizing agent that can be used in the present invention includes, for example, sulfur and the like, and the using amount thereof is 0.1 to 10 parts by weight, preferably 0.5 to 5 parts by weight in terms of a sulfur content per 100 parts by weight of the rubber component. The amount of less than 0.1 part by weight tends to reduce the breaking characteristic and the abrasion resistance of the vulcanized rubber, and the amount exceeding 10 parts by weight tends to cause the rubber elasticity to be lost.

[0062] The process oil that can be used in the present invention includes, for example, paraffin base, naphthene base and aromatic base. The aromatic base is used for uses in which the breaking characteristic and the abrasion resistance are regarded as important, and the naphthene base or the paraffin base is used for uses in which the low heat generation property and the low temperature characteristic are regarded as important. The using amount thereof is 0 to 100 parts by weight per 100 parts by weight of the rubber material. The amount exceeding 100 parts by weight markedly degrades the breaking characteristic and the low heat generation property of the vulcanized rubber.

[0063] The vulcanization accelerators that can be used in the present invention shall not specifically be restricted and include preferably vulcanization accelerators of thiazole base such as 2-mercaptobenzothiazole (MBT) and dibenzothiazolyl disulfide (DM), sulfenamide base such as N-cyclohexyl-2-benzothiazolyl sulfenamide (CBS), N,N'-dicyclohexyl-2-benzothiazolyl sulfenamide and N-t-butyl-2-benzothiazolyl sulfenamide (BBS), and guanidine base such as diphenylguanidine (DPG). The using amount thereof is 0.1 to 5 parts by weight, preferably 0.2 to 3 parts by weight per 100 parts by weight of the rubber component.

[0064] The rubber composition of the present invention can be obtained by mixing the rubber component, the reinforcing filler, the compounds represented by Formulas (I) to (IV) described above and the like by means of a mixer such as a roll and an internal mixer. After the rubber composition is molded, it is vulcanized and can be used for industrial uses such as rubber vibration isolators, belts, hoses and other industrial articles as well as tire uses such as tire treads, under-treads, carcasses, side walls and bead parts. In particular, the rubber composition of the present invention is suitably used as rubber for tire tread.

EXAMPLES

[0065] The present invention shall be explained below in further detail with reference to synthetic examples, examples and comparative examples, but the present invention shall not be restricted to these examples.

[0066] Rubber compositions obtained in Examples and Comparative Examples were evaluated by the following testing methods to determine their characteristics.

(1) Mooney scorch test:

[0067] Carried out based on JIS K6300-1974. Measurement was conducted at 130°C in the Mooney scorch test. MST (Mooney scorch time) in the Mooney scorch test is to evaluate liability to scorching of rubber at the time of molding rubber as in extruding and calendaring, and the smaller the value is, the more the workability is degraded.

(2) Tensile test:

[0068] The tensile test was carried out based on JIS K6301-1975 to determine an elongation at break (Eb), a tensile strength at break (Tb), a 100 % modulus (M100) and a 300 % modulus (M300).

(3) Hardness:

[0069] The hardness (Hd) was determined based on JIS K6301-1975.

(4) Air-heating aging test:

[0070] A sample was subjected to aging at a test temperature of $100 \pm 1^\circ\text{C}$ for 24 and 48 hours in a gear oven and then left standing at room temperature for 5 hours or longer. Subsequently, the tensile test described above was carried out in the same way as the case with the sample before aging.

[0071] All data were shown by index, wherein the measured value of a blank test (Comparative Example 1) in which no hydrazide compound was added was set at 100. The change rate was calculated from the following equation:

(5) Evaluation of heat generation property:

[0072] The heat generation property of the vulcanized rubber was evaluated by determining $\tan \delta$ at 25°C . The $\tan \delta$ (25°C) was determined under the conditions of a dynamic distortion of 1 % in stretching at a temperature of 25°C and a frequency of 10 MHz by means of a mechanical spectrometer manufactured by Rheometrics Inc. U.S.

[0073] A reciprocal number of each $\tan \delta$ obtained was shown by index to show the low heat generation property, wherein the value of a control (Comparative Example 3 in which no hydrazide compound was added) was set at 100.

[0074] It is meant that the larger the value of the low heat generation property index is, the larger the effect of low heat generation property by the hydrazide compounds is.

Synthetic Examples 1 to 13

[0075] Among the compounds represented by Formulas (I) and (II) in the present invention, N^2, N^4 -di(1-methylethylidene)isophthalodihydrazide, N' -(1-methylethylidene)benzohydrazide, N' -diphenylmethylenebenzohydrazide, N' -(1,3-dimethylbutylidene)benzohydrazide, N' -(1,3-dimethylbutylidene)salicylohydrazide, N' -(2-furylmethylene)salicylohydrazide, 1-hydroxy- N' -(1,3-dimethylbutylidene)-2-naphthohydrazide, 3-hydroxy- N' -(1-methylethylidene)-2-naphthohydrazide, 3-hydroxy- N' -(1-methylpropylidene)-2-naphthohydrazide, 3-hydroxy- N' -(1,3-dimethylbutylidene)-2-naphthohydrazide, 3-hydroxy- N' -(1-furylmethylene)-2-naphthohydrazide, 3-hydroxy- N' -(2-furylmethylene)-2-naphthohydrazide and N' -(1-methylethylidene)isonicotinohydrazide which were the typical compounds were synthesized by the following methods:

Synthetic Example 1: synthesis of N^2, N^4 -di(1-methylethylidene)isophthalodihydrazide

[0076] A four neck flask (1 liter) equipped with a thermometer, a reflux condenser and a stirrer was charged with 58.2 g (0.3 mol) of isophthalohydrazide and 500 ml of acetone and then heated under reflux for 24 hours. The reaction liquid was cooled down to 20°C or lower, and then crystal was filtered off and dried under reduced pressure, whereby the intended compound (white crystal) was obtained.

[0077] The amount yielded in this reaction was 81.2 g (0.23 mol), and the yield was 98 %.

Melting point: 245°C

$^1\text{H-NMR}$ (DMSO) 1.93 (s, 6H), 1.99 (s, 6H), 7.60 to 8.30 (m, 4H), 10.54 (b, 2H)

[0078] The yield shows mol % (hereinafter the same shall apply regarding the yield).

Synthetic Example 2: synthesis of N' -(1-methylethylidene)benzohydrazide

[0079] A four neck flask (1 liter) equipped with a thermometer, a reflux condenser and a stirrer was charged with 136 g (1.0 mol) of benzohydrazide and 600 ml of acetone and then heated under reflux for 12 hours. The reaction liquid was cooled down to 5°C or lower, and then crystal was filtered off and dried under reduced pressure, whereby white crystal was obtained.

[0080] The amount yielded in this reaction was 148 g (0.84 mol), and the yield was 84 %.

Melting point: 143°C

$^1\text{H-NMR}$ (DMSO) 1.92 (s, 3H), 1.98 (s, 3H), 7.40 to 7.95 (m, 5H), 10.42 (b, 1H)

Synthetic Example 3: synthesis of N' -diphenylmethylenebenzohydrazide

[0081] A four neck flask (1 liter) equipped with a thermometer, a reflux condenser and a stirrer was charged with 68.0 g (0.5 mol) of benzohydrazide, 700 ml of methanol and 3.5 ml of acetic acid. Added thereto was 109.2 g (0.6 mol) of benzophenone while stirring at room temperature, and heating under reflux was continued for 12 hours. The reaction

liquid was cooled down to 5°C or lower, and then crystal was filtered off and dried under reduced pressure, whereby white crystal was obtained.

[0082] The amount yielded in this reaction was 103 g (0.34 mol), and the yield was 68 %.

Melting point: 116°C

¹H-NMR (DMSO) 7.30 to 7.70 (m, 15H), 10.05 (b, 1H)

Synthetic Example 4: synthesis of N'-(1,3-dimethylbutylidene)benzohydrazide

[0083] A four neck flask (2 liters) equipped with a thermometer, a Dean-Stark type reflux condenser and a stirrer was charged with 68.0 g (0.5 mol) of benzohydrazide and 600 ml of methyl isobutyl ketone and then heated under reflux for 5 hours. The reaction liquid was cooled down to 5°C or lower, and then crystal was filtered off and dried under reduced pressure, whereby white crystal was obtained.

[0084] The amount yielded in this reaction was 89.6 g (0.41 mol), and the yield was 82 %.

Melting point: 110°C

¹H-NMR (DMSO) 0.95 (m, 6H), 1.80 to 2.30 (m, 6H), 7.40 to 7.95 (m, 5H), 10.5 (b, 1H)

Synthetic Example 5: synthesis of N'-(1,3-dimethylbutylidene)salicylohydrazide

[0085] A reactor equipped with a Dean-Stark type reflux condenser and a stirrer was charged with 1.7 liter of methyl isobutyl ketone and 190.2 g (1.25 mol) of salicylohydrazide and then heated under reflux for 5 hours while removing distilled water. The reaction liquid was cooled down to 20°C, and then crystal deposited was filtered off and dried under reduced pressure, whereby white crystal was obtained.

[0086] The amount yielded in this reaction was 261 g, and the yield was 89 %.

[0087] It was found from results of NMR and IR analyses that this substance was N'-(1,3-dimethylbutylidene)salicylohydrazide.

Melting point: 158°C

¹H-NMR (DMSO) 0.90 (m, 6H), 1.89 (s, 3H), 1.97 (m, 1H), 2.15 (m, 2H), 6.95 (m, 2H), 7.35 (m, 1H), 7.93 (m, 1H), 11.00 (b, 1H), 11.75 (b, 1H)

IR (KBr) 3400 to 2400, 1650, 1550, 1500, 1480, 1390, 1310, 1250, 1160, 1150, 1100, 1060, 910, 760, 660, 570, 540, 480 cm⁻¹

Synthetic Example 6: synthesis of N'-(2-furylmethylene)salicylohydrazide

[0088] A four neck flask (2 liters) equipped with a thermometer, a reflux condenser and a stirrer was charged with 76.1 g (0.5 mol) of salicylohydrazide and 1 liter of methanol, and 57.6 g (0.6 mol) of furfural was dropwise added thereto in 30 minutes while stirring at room temperature. After heating under reflux for 2 hours, the reaction liquid was cooled down to 20°C or lower, and crystal was filtered off. The crystal was washed with a small amount of methanol and then dried under reduced pressure, whereby the intended compound (slightly yellow crystal) was obtained. The amount yielded in this reaction was 108.1 g (0.47 mol), and the yield was 93 %.

Melting point: 211°C

¹H-NMR (DMSO) 6.60 to 8.50 (m, 10H), 11.2 (b, 1H), 11.9 (b, 1H)

Synthetic Example 7: synthesis of 1-hydroxy-N'-(1,3-dimethylbutylidene)-2-naphthohydrazide

[0089] A reactor equipped with a Dean-Stark type reflux condenser and a stirrer was charged with 500 ml of methyl isobutyl ketone and 50.0 g (0.25 mol) of 1-hydroxy-2-naphthohydrazide and then heated under reflux for 5 hours while removing distilled water. The reaction liquid was cooled down to 20°C, and then the solvent was distilled off by means of a rotary evaporator. Crystal was recrystallized from diethyl ether, whereby slightly yellow crystal was obtained.

[0090] The amount yielded in this reaction was 69.8 g, and the yield was 98 %.

[0091] It was found from results of NMR and IR analyses that this substance was 1-hydroxy-N'-(1,3-dimethylbutylidene)-2-naphthohydrazide.

Melting point: 101°C

¹H-NMR (DMSO) 0.90 (m, 6H), 2.00 (m, 4H), 2.23 (m, 2H), 7.93 (m, 1H), 7.56 (m, 2H), 7.88 (m, 2H), 8.25 (m, 1H),

10.87 (b, 1H), 14.15 (b, 1H)

IR (KBr) 3400 to 2600, 1620, 1595, 1530, 1510, 1470, 1420, 1390, 1360, 1340, 1290, 1270, 1205, 1160, 1150, 820, 790, 760 cm^{-1}

5 Synthetic Example 8: synthesis of 3-hydroxy-N'-(1-methylethylidene)-2-naphthohydrazide

[0092] A four neck flask (3 liters) equipped with a thermometer, a reflux condenser and a stirrer was charged with 121.2 g (0.6 mol) of 3-hydroxy-2-naphthohydrazide, 1.14 g (0.006 mol) of p-toluenesulfonic acid and 2 liters of acetone and then heated under reflux for 5 hours. The reaction liquid was cooled down to 20°C or lower, and then crystal was
10 filtered off and dried under reduced pressure, whereby the intended compound (slightly yellow crystal) was obtained.
[0093] The amount yielded in this reaction was 130.5 g (0.54 mol), and the yield was 90 %.

Melting point: 241°C

¹H-NMR (DMSO) 1.96 (s, 3H), 2.03 (s, 3H), 7.32 (m, 2H), 7.50 (m, 1H), 7.75 (m, 1H), 7.95 (m, 1H), 8.57 (s, 1H),
15 11.2 (b, 1H), 11.62 (b, 1H)

Synthetic Example 9: synthesis of 3-hydroxy-N'-(1-methylpropylidene)-2-naphthohydrazide

[0094] A four neck flask (3 liters) equipped with a thermometer, a reflux condenser and a stirrer was charged with
20 121.2 g (0.6 mol) of 3-hydroxy-2-naphthohydrazide and 2 liters of methyl ethyl ketone and then heated under refluxing for 5 hours. The reaction liquid was cooled down to 20°C or lower, and then crystal was filtered off and dried under reduced pressure, whereby the intended compound (slightly yellow crystal) was obtained.
[0095] The amount yielded in this reaction was 135.1 g (0.53 mol), and the yield was 88 %.

25 Melting point: 240°C

¹H-NMR (DMSO) 0.92 to 1.15 (m, 3H), 1.90 to 2.05 (m, 3H), 2.25 to 2.42 (m, 2H), 7.75 to 8.60 (m, 6H), 11.00 to 11.30 (b, 2H)

Synthetic Example 10: synthesis of 3-hydroxy-N'-(1,3-dimethylbutylidene)-2-naphthohydrazide

30 [0096] A reactor equipped with a Dean-Stark type reflux condenser and a stirrer was charged with 500 ml of methyl isobutyl ketone and 50.0 g (0.25 mol) of 3-hydroxy-2-naphthohydrazide and then heated under reflux for 5 hours while removing distilled water. The reaction liquid was cooled down to 20°C, and then crystal deposited was filtered off and dried under reduced pressure, whereby slightly yellow crystal was obtained.
35 [0097] The amount yielded in this reaction was 67.6 g, and the yield was 95 %.
[0098] It was found from results of NMR and IR analyses that this substance was 3-hydroxy-N'-(1,3-dimethylbutylidene)-2-naphthohydrazide.

Melting point: 146°C

40 ¹H-NMR (DMSO) 0.90 (m, 6H), 1.93 (s, 3H), 2.00 (m, 1H), 2.17 (m, 2H), 7.38 (m, 2H), 7.46 (m, 1H), 7.75 (m, 1H), 7.95 (m, 1H), 8.58 (m, 1H), 11.15 (b, 1H), 11.65 (b, 1H)
IR (KBr) 3400 to 2400, 1650, 1550, 1510, 1470, 1360, 1230, 1170, 1140, 1120, 1050, 950, 900, 880, 770, 740, 670, 600, 550, 480 cm^{-1}

45 Synthetic Example 11: synthesis of 3-hydroxy-N'-(1-phenylmethylene)-2-naphthohydrazide

[0099] A four neck flask (2 liters) equipped with a thermometer, a reflux condenser and a stirrer was charged with 101 g (0.5 mol) of 3-hydroxy-2-naphthohydrazide and 1.5 liter of methanol, and 63.7 g (0.6 mol) of benzaldehyde was drop-wise added thereto in 30 minutes while stirring at room temperature. After heating under reflux for 5 hours, the reaction
50 liquid was cooled down to 15°C or lower, and crystal was filtered off. The crystal was washed with a small amount of methanol and then dried under reduced pressure, whereby the intended compound (slightly yellow crystal) was obtained.
[0100] The amount yielded in this reaction was 133.4 g (0.46 mol), and the yield was 92 %.

55 Melting point: 232°C

¹H-NMR (DMSO) 7.20 to 8.50 (m, 12H), 11.60 to 12.00 (b, 2H)

Synthetic Example 12: synthesis of 3-hydroxy-N'-(2-furylmethylene)-2-naphthohydrazide

[0101] A four neck flask (2 liters) equipped with a thermometer, a reflux condenser and a stirrer was charged with 101 g (0.5 mol) of 3-hydroxy-2-naphthohydrazide and 1.5 liter of methanol, and 57.6 g (0.6 mol) of furfural was dropwise added thereto in 30 minutes while stirring at room temperature. After heating under reflux for 5 hours, the reaction liquid was cooled down to 20°C or lower, and crystal was filtered off. The crystal was washed with a small amount of methanol and then dried under reduced pressure, whereby the intended compound (slightly yellow crystal) was obtained.

[0102] The amount yielded in this reaction was 118.6 g (0.42 mol), and the yield was 84 %.

Melting point: 211°C

¹H-NMR (DMSO) 6.60 to 8.50 (m, 10H), 11.2 (b, 1H), 11.9 (b, 1H)

Synthetic Example 13: synthesis of N'-(1-methylethylidene)isonicotinohydrazide

[0103] A four neck flask (1 liter) equipped with a thermometer, a reflux condenser and a stirrer was charged with 68.5 g (0.5 mol) of isonicotinohydrazide and 500 ml of acetone and then heated under reflux for 24 hours. The reaction liquid was cooled down to 20°C or lower, and then crystal was filtered off and dried under reduced pressure, whereby the intended compound (white crystal) was obtained.

[0104] The amount yielded in this reaction was 74.0 g (0.42 mol), and the yield was 84 %.

Melting point: 162°C

¹H-NMR (DMSO) 1.92 (s, 3H), 1.99 (s, 3H), 7.71 (m, 2H), 8.70 (m, 2H), 10.69 (b, 1H)

Examples 1 to 9 and Comparative Examples 1 to 2

[0105] Components shown in Table 1 and Table 2 were mixed and compounded by means of Labo Plastomill of 250 ml and a 3-inch roll.

[0106] Compounded rubbers (non-vulcanized) obtained in Examples 1 to 9 and Comparative Examples 1 to 2 were subjected to a Mooney scorch test. Further, these compounded rubbers were subjected to a tensile test and an air-heating aging test after vulcanization. These results are shown in the following Table 1 and Table 2.

Table 1

Components	Parts by weight
Natural rubber	100
Reinforcing filler *1	40
Stearic acid	2.5
Antioxidant *2	1.0
Hydrazide compound	Table 2 & Table 3
ZnO	5.0
CBS *3	1.0
Sulfur	2.0

*1: HAF grade carbon black

*2: Nocrac 6C (manufactured by Ohuchi Shinko Chemical Ind. Co., Ltd.) [N-(1,3-dimethylbutyl)-N'-phenyl-p-phenylenediamine]

*3: Nocceler CZ (manufactured by Ohuchi Shinko Chemical Ind. Co., Ltd.) [N-cyclohexyl-2-benzothiazolyl sulfenamide]

Table 2

		Comparative Example		Example			
		1	2	1	2	3	4
		Blank	Chemical A	Chemical B	Chemical C	Chemical D	Chemical D
	Blending amount (part by weight)		1.0	1.0	1.0	1.0	0.5
Mooney test (130°C)	ML 1+4	100	124	103	98	98	98
	MST	100	25	55	67	83	91
Tensile test	EB	100	95	102	100	96	99
	TB	100	98	98	98	90	98
	M300	100	103	93	100	87	98
Tensile test after aging at 100°C for 24 hours	EB	100	102	106	105	104	102
	TB	100	103	101	101	101	102
	M300	100	103	92	96	98	98
Change rate (%)	EB	80	85	83	84	88	83
	TB	93	97	85	95	104	96
	M300	142	125	141	136	144	141
Tensile test after aging at 100°C for 48 hours	EB	100	110	111	109	109	105
	TB	100	114	106	106	108	103
	M300	100	105	92	98	97	98
Change rate (%)	EB	71	80	76	76	81	75
	TB	81	93	87	87	96	85
	M300	152	147	150	149	152	151

Table 2 (continued)

		Example					
		5	6	7	8	9	
		Chemical D	Chemical D	Chemical D	Chemical E	Chemical F	
	Blending amount (part by weight)	2.0	3.0	5.0	1.0	1.0	
Mooney test (130°C)	ML 1+4 MST	84	90	86	98	101	
		80	76	72	88	71	
Tensile test	EB	101	102	104	103	102	
	TB	95	94	94	98	95	
	M300	86	93	91	94	92	
Tensile test after aging at 100°C for 24 hours	EB	112	112	114	115	105	
	TB	103	100	102	104	97	
	M300	98	95	91	89	92	
Change rate (%)	EB	89	88	98	90	83	
	TB	100	99	100	98	95	
	M300	145	145	143	134	142	
Tensile test after aging at 100°C for 48 hours	EB	120	124	122	114	111	
	TB	114	111	109	107	101	
	M300	96	90	90	89	89	
Change rate (%)	EB	84	86	83	78	77	
	TB	96	95	94	98	86	
	M300	152	148	150	145	148	

[0107] Chemicals A to F shown in Table 2 are as follows:

Chemical A: benzohydrazide

Chemical B: N'-(1-methylethylidene)benzohydrazide
 Chemical C: N'-benzylidenebenzohydrazide
 Chemical D: N'-diphenylmethylenebenzohydrazide
 Chemical E: N'-(2-furylmethylidene)benzohydrazide
 5 Chemical F: N'-diphenylmethylenepropionohydrazide

Comments on Table 2:

10 [0108] As apparent from the results shown in Table 2 described above, it has been confirmed that in Examples 1 to 19 falling in the scope of the present invention, the workability can be highly compatible with the rubber physical properties after aging as compared with Comparative Examples 1 to 2 falling outside the scope of the present invention.

[0109] To observe specifically, it can be found that in Comparative Example 2, an improving effect of EB and TB after aging is provided by benzohydrazide but MST is reduced to 1/4 and the workability is deteriorated to a large extent.

15 [0110] In contrast with this, it can be found that in Examples 1 to 4 and 8 to 9, MST is prolonged to a large extent by turning benzohydrazide and propionohydrazide into hydrazones and that an improving effect of EB and TB after aging is almost maintained or elevated. Among them, N'-diphenylmethylenebenzohydrazide used in Examples 3 to 7 has a high aging-resistant effect and exerts a smaller influence on MST, and therefore the use of 0.5 part by weight or more thereof can allow the workability to be compatible with the after-aging breaking properties at a high level.

20 Examples 10 to 28 and Comparative Examples 3 to 10

[0111] Components shown in Table 1 (some were changed in a rubber kind partially from natural rubber to synthetic rubber) and Table 3 were mixed and compounded by means of Labo Plastomill of 250 ml and a 3-inch roll. The respective compounded rubbers were vulcanized at 145°C for 35 minutes and then subjected to measurement of a Mooney
 25 viscosity, a tensile test and an aging test. Further, the heat generation property was evaluated. These results are shown in Table 3.

Table 3

		Comparative Example					
		3	4	5	6	7	8
		Blank	Chemical G	Chemical G	Chemical G	Chemical P	Chemical R
Mooney test (130°C)	Blending amount (part by weight)		0.5	1.0	1.5	1.0	1.0
	Kind of rubber	*1	*1	*1	*1	*1	*1
Tensile test	ML 1+4	42	47	50	56	65	45
	MST	16.0	13.0	9.8	6.1	13.0	7.8
	EB	100	101	108	115	99	96
Tensile test after aging at 100°C for 48 hours	TB	100	99	100	102	98	99
	M300	100	98	95	93	101	95
	EB	100	107	122	131	102	97
Change rate (%)	TB	100	104	110	113	99	97
	M300	100	97	92	89	102	94
	EB	71	75	80	81	73	72
Low heat build-up index	TB	81	85	89	90	82	79
	M300	152	150	147	146	153	150
		100	137	144	152	155	132

*1: Natural rubber 100 parts by weight

*2: Natural rubber 60 parts by weight

BR01 (manufactured by Japan Synthetic Rubber Co., Ltd.) 40 parts by weight

*3: Natural rubber 50 parts by weight

SBR01500 (manufactured by Japan Synthetic Rubber Co., Ltd.) 50 parts by weight

Table 3 (continued)

		Example				
		10	11	12	13	14
		Chemical H	Chemical H	Chemical H	Chemical H	Chemical I
	Blending amount (part by weight)	0.5	1.0	1.5	2.0	1.0
	Kind of rubber	*1	*1	*1	*1	*1
	ML 1+4	42	43	44	46	43
Mooney test (130°C)	MST	15.5	14.3	12.5	11.2	13.8
Tensile test	EB	102	104	110	118	105
	TB	101	102	102	101	103
	M300	105	102	100	98	102
Tensile test after aging at 100°C for 48 hours	EB	106	119	127	136	118
	TB	103	111	112	110	111
	M300	102	98	95	93	100
Change rate (%)	EB	74	81	82	82	80
	TB	83	88	89	88	87
	M300	148	146	144	144	149
Low heat build-up index		131	140	150	152	133

Table 3 (continued)

		Example					
		15	16	17	18	19	
		Chemical J	Chemical K	Chemical K	Chemical K	Chemical K	
	Blending amount (part by weight)	1.0	0.5	1.0	1.5	2.0	
	Kind of rubber	*1	*1	*1	*1	*1	
Mooney test (130°C)	ML 1+4	44	43	43	44	44	
	MST	14.2	15.8	14.9	13.8	12.4	
Tensile test	EB	103	101	105	112	117	
	TB	102	104	104	103	102	
	M300	103	107	104	103	101	
Tensile test after aging at 100°C for 48 hours	EB	119	107	117	129	133	
	TB	108	108	108	108	106	
	M300	96	103	99	96	93	
Change rate (%)	EB	82	75	79	82	81	
	TB	86	84	84	85	84	
	M300	142	147	145	142	140	
Low heat build-up index		131	130	142	152	153	

Table 3 (continued)

		Example				
		20	21	22	23	24
		Chemical L	Chemical M	Chemical N	Chemical O	Chemical Q
	Blending amount (part by weight)	1.0	1.0	1.0	1.0	1.0
	Kind of rubber	*1	*1	*1	*1	*1
Mooney test (130°C)	ML 1+4	42	44	42	41	55
	MST	15.1	14.5	14.6	13.1	14.2
Tensile test	EB	106	97	95	108	97
	TB	105	103	104	101	96
	M300	105	111	112	103	104
Tensile test after aging at 100°C for 48 hours	EB	121	107	106	123	101
	TB	110	109	110	108	98
	M300	100	108	107	98	104
Change rate (%)	EB	81	78	79	81	74
	TB	85	86	86	87	83
	M300	145	148	145	145	152
Low heat build-up index		127	135	141	145	146

Table 3 (continued)

	Example	*4		*5	
		Comparative Example	Example	Comparative Example	Example
	25	9	26	10	27
	Chemical S	Blank	Chemical K	Blank	Chemical K
	1.0		1.0		1.0
	Kind of rubber	*1	*2	*3	*3
Mooney test (130°C)	ML 1+4	46	48	50	52
	MST	15.2	13.8	13.5	12.5
Tensile test	EB	100	105	100	102
	TB	100	103	100	101
	M300	100	98	100	101
Tensile test after aging at 100°C for 48 hours	EB	100	115	100	109
	TB	100	121	100	110
	M300	100	100	100	108
Change rate (%)	EB	76	83	78	83
	TB	80	94	88	96
	M300	123	126	150	160
Low heat build-up index	130	100	137	100	125

*4: The physical properties of Example 26 are shown by index, wherein those of Comparative

Example 9 are set at 100.

*5: The physical properties of Example 27 are shown by index, wherein those of Comparative

Example 10 are set at 100.

[0112] Chemicals G to S shown in Table 3 are as follows:

Chemical G:	3-hydroxy-2-naphthohydrazide
Chemical H:	3-hydroxy-N'-(1-methylethylidene)-2-naphthohydrazide
Chemical I:	3-hydroxy-N'-(1-methylpropylidene)-2-naphthohydrazide
Chemical J:	3-hydroxy-N'-(1-methylbutylidene)-2-naphthohydrazide
5 Chemical K:	3-hydroxy-N'-(1,3-dimethylbutylidene)-2-naphthohydrazide
Chemical L:	3-hydroxy-N'-(1-phenylethylidene)-2-naphthohydrazide
Chemical M:	N'-(1-methylethylidene)salicylohydrazide
Chemical N:	N'-(1,3-dimethylbutylidene)salicylohydrazide
Chemical O:	1-hydroxy-N'-(1,3-dimethylbutylidene)-2-naphthohydrazide
10 Chemical P:	isophthalodihydrazide
Chemical Q:	N ² ,N ⁴ -di(1-methylethylidene)isophthalodihydrazide
Chemical R:	isonicotinohydrazide
Chemical S:	N'-(1-methylethylidene)isonicotinohydrazide

15 Comments on Table 3:

[0113] It can be found that as shown in Comparative Examples 3 to 8, conventional hydrazide compounds [Chemical G (3-hydroxy-2-naphthohydrazide), Chemical P (isophthalodihydrazide) and Chemical R (isonicotinohydrazide)] provide a high low heat generation property effect but cause a reduction in MST as well as a big rise in the Mooney viscosity.

[0114] In contrast with this, it has been confirmed that Chemical H [3-hydroxy-N'-(1-methylethylidene)-2-naphthohydrazide] is a little inferior in a low heat generation property in the same blending amount as compared with Chemical G but reduces the Mooney viscosity by 5 to 10 points and improves the workability to a large extent.

[0115] Further, as shown in Comparative Examples 4, 5 and 6, Examples 10, 11, 12 and 13 and Examples 16, 17, 18 and 19, an increase in the amounts of chemical H and Chemical K can achieve the low Mooney viscosity while lowering the heat generation property to the level that is equal to or less than Chemical G. It can also be found that the same effect can be obtained as well in Chemical I (Example 14), Chemical J (Example 15), Chemical L (Example 20), Chemical M (Example 21), Chemical N (Example 22) and Chemical O (Example 23).

[0116] Further, it has been confirmed that also when Chemical Q [N²,N⁴-di(1-methylethylidene)isophthalodihydrazide] and Chemical S [N'-(1-methylethylidene)isonicotinohydrazide] were used in place of Chemical P and Chemical R, the Mooney viscosity is reduced to a large extent while maintaining the same low heat generation property (Comparative Example 7 and Example 24 and Comparative Example 8 and Example 25).

[0117] Further, it has been confirmed that when the kind of rubber was changed and the case where Chemical K was used was compared with the case where no compound was added, the Mooney viscosity is reduced to a large extent while maintaining similarly the low heat generation property (Comparative Example 9 and Example 26 and Comparative Example 10 and Example 27).

Synthetic Examples 14 to 18

[0118] Among the compounds represented by Formula (III) in the present invention, five typical compounds of N-benzoyl-N'-phenylhydrazine, N-benzoyl-N'-salicyloylhydrazine, N-(3-hydroxy-2-naphthoyl)-N'-benzoylhydrazine, 1-benzamido-guanidine and 1-benzoylsemicarbazide were synthesized by the following methods:

Synthetic Example 14: synthesis of N-benzoyl-N'-phenylhydrazine

[0119] A four neck flask (2 liters) equipped with a thermometer and a stirrer was charged with 216 g (2.0 mol) of phenylhydrazine and 1.5 liter of ether and cooled down to 5°C. Dropwise added thereto was 56.2 g (0.4 mol) of benzoyl chloride in 2 hours while stirring, and then the solution was heated to room temperature (20°C) to continue stirring for 12 hours. Crystal was filtered off and washed sufficiently with deionized water and then dried under reduced pressure to obtain slightly brown crystal.

[0120] The amount yielded in this reaction was 61 g (0.29 mol), and the yield was 72 %.

Melting point: 169°C

¹H-NMR (DMSO) 6.66 to 7.95 (m, 11H), 10.36 (b, 1H)

Synthetic Example 15: synthesis of N-benzoyl-N'-salicyloylhydrazine

[0121] A four neck flask (1 liter) equipped with a thermometer and a stirrer was charged with 60.8 g (0.4 mol) of sal-

icylohydrazide, 49.2 g (0.6 mol) of sodium acetate and 700 ml of acetic acid. Dropwise added thereto was 67.4 g (0.48 mol) of benzoyl chloride in one hour while stirring, and stirring was continued at room temperature (20°C) for 3 hours. After finishing the reaction, 1.5 liter of deionized water was added and crystal was filtered off. After washing sufficiently the crystal with 500 ml of methanol, it was dried under reduced pressure to obtain slightly brown crystal.

5 [0122] The amount yielded in this reaction was 96 g (0.37 mol), and the yield was 94 %.

Melting point: 256°C

¹H-NMR (DMSO) 6.80 to 8.00 (m, 9H), 10.65 (s, 2H), 11.92 (s, 1H)

10 Synthetic Example 16: synthesis of N-(3-hydroxy-2-naphthoyl)-N'-benzoylhydrazine

[0123] A four neck flask (1 liter) equipped with a thermometer and a stirrer was charged with 60.6 g (0.3 mol) of 3-hydroxy-2-naphthohydrazide, 36.9 g (0.45 mol) of sodium acetate and 800 ml of acetic acid and heated to 30°C. Dropwise added thereto was 50.6 g (0.36 mol) of benzoyl chloride in one hour while stirring, and stirring was continued at 30°C for one hour. After finishing the reaction, the reaction liquid was added to 1.5 liter of deionized water and crystal was filtered off. After washing sufficiently the crystal with 1 liter of deionized water and 500 ml of methanol, it was dried under reduced pressure to obtain slightly brown crystal.

15 [0124] The amount yielded in this reaction was 86 g (0.28 mol), and the yield was 93 %.

20 Melting point: 256°C

¹H-NMR (DMSO) 7.30 to 8.00 (m, 10H), 8.55 (s, 1H), 10.78 (b, 2H), 11.45 (b, 1H)

Synthetic Example 17: synthesis of 1-benzamidoguanidine

25 [0125] A four neck flask (2 liters) equipped with a thermometer and a stirrer was charged with 88.5 g (1.0 mol) of aminoguanidine hydrochloride, 205 g (2.5 mol) of sodium acetate and 1 liter of acetic acid and cooled down to 10°C. Dropwise added thereto was 154.5 g (1.1 mol) of benzoyl chloride while stirring, and stirring was continued at room temperature (20°C) for 12 hours. After filtering off crystal, the mother liquid was concentrated to obtain an oily substance. This was dissolved in 1 liter of deionized water, and a 48 % sodium hydroxide aqueous solution was dropwise added until the pH became 13 or higher. Crystal deposited was filtered off and washed with 200 ml of deionized water, and then the crystal was dried under reduced pressure to obtain slightly brown crystal.

30 [0126] The amount yielded in this reaction was 111 g (0.73 mol), and the yield was 71 %.

Melting point: 185°C

35 ¹H-NMR (DMSO) 6.80 to 7.20 (b, 4H), 7.25 (m, 3H), 7.90 (m, 2H), 10.80 (b, 1H)

Synthetic Example 18: synthesis of 1-benzoylsemicarbazide

40 [0127] A four neck flask (1000 ml) equipped with a thermometer and a stirrer was charged with 78.2 g (0.75 mol) of 35 % hydrochloric acid and 700 ml of deionized water. Added thereto was 68.0 g (0.5 mol) of benzohydrazide at room temperature (20°C) while stirring, and then 60.7 g (0.75 mol) of potassium cyanate was gradually added in 30 minutes. Stirring was continued at 30°C for one hour, and then crystal was filtered off and washed with 200 ml of deionized water. This was dried under reduced pressure to obtain white crystal.

[0128] The amount yielded in this reaction was 71.7 g (0.4 mol), and the yield was 80 %.

45 Melting point: 220°C

¹H-NMR (DMSO) 6.00 (b, 2H), 7.40 to 7.90 (m, 6H), 10.10 (b, 1H)

Examples 28 to 37 and Comparative Examples 11 to 14

50 [0129] Rubber compositions containing the components shown in the following Table 4 and Table 5 were mixed by means of a Banbury mixer and then molded to sheets (160 mm × 160 mm) having a thickness of about 2 mm, followed by pressing cure at 145°C for 30 minutes.

[0130] The vulcanized rubbers obtained in Examples 28 to 37 and Comparative Examples 11 to 14 were subjected to a tensile test before heat aging and after heat-aging in the air under the conditions of 100°C and 48 hours to determine a 100 % modulus and an elongation at break (%).

55 [0131] These results are shown in the following Table 5.

Table 4

Components	Parts by weight
Natural rubber	70
Synthetic rubber *1	30
Reinforcing filler *2	50
Stearic acid	2.0
Zinc oxide	3.0
Antioxidant *3	Table 5
Hydrazide compound	Table 5
Vulcanization accelerator *4	1.0
Sulfur	1.2

*1: JSR BR01 (manufactured by Japan Synthetic Rubber Co., Ltd.)

*2: ISAF grade carbon black

*3: Nocrac 6C (manufactured by Ohuchi Shinko Chemical Ind. Co., Ltd.) [N-(1,3-dimethylbutyl)-N'-phenyl-p-phenylenediamine]

*4: Nocceler CZ (manufactured by Ohuchi Shinko Chemical Ind. Co., Ltd.) [N-cyclohexyl-2-benzothiazolyl sulfenamide]

Table 5

Numerals in parentheses are a change in rate before and after heat aging

	Hydrazide compound	Blending amount (part by weight)		Before heat aging		After heat aging	
		Chemical F	Hydrazide compound	M100	Elongation at break (Eb) (%)	M100	Elongation at break (Eb) (%)
Comparative Example 11	No addition	0.00	0.00	1.71	545.2	2.13 (125)	389.1 (71)
Example 28	Chemical A	0.00	1.00	2.25	535.1	3.05 (136)	441.8 (83)
Example 29	Chemical A	0.00	2.00	2.37	532.4	3.11 (131)	475.3 (89)
Comparative Example 12	No addition	1.00	0.00	2.11	527.2	3.13 (148)	398.7 (76)
Comparative Example 13	No addition	2.00	0.00	2.45	520.0	4.41 (180)	397.8 (77)
Comparative Example 14	No addition	5.00	0.00	1.90	578.8	3.99 (210)	392.4 (68)
Example 30	Chemical B	1.00	1.00	1.87	538.9	2.58 (138)	490.6 (91)
Example 31	Chemical C	1.00	1.00	2.03	531.2	2.71 (134)	485.5 (91)
Example 32	Chemical D	1.00	1.00	2.74	521.1	3.50 (128)	475.0 (91)

Table 5 (continued)

	Hydrazide compound	Blending amount (part by weight)		Before heat aging		After heat aging	
		Chemical F	Hydrazide compound	M100	Elongation at break (Eb) (%)	M100	Elongation at break (Eb) (%)
Example 33	Chemical E	1.00	1.00	2.54	526.5	3.17 (125)	488.0 (93)
Example 34	Chemical A	1.00	1.00	2.61	526.0	3.19 (122)	489.5 (93)
Example 35	Chemical A	1.00	2.00	2.65	525.2	3.18 (120)	488.4 (93)
Example 36	Chemical A	1.00	3.00	2.71	520.3	3.22 (119)	492.7 (95)
Example 37	Chemical A	1.00	0.50	2.37	531.0	3.13 (132)	472.3 (89)

Chemical A: N-benzoyl-N'-t-butylhydrazine

Chemical B: N-benzoyl-N'-phenylhydrazine

Chemical C: N,N'-dibenzoylhydrazine

Chemical D: 1-benzoylsemicarbazide

Chemical E: 1-benzamidoguanidine

Chemical F: N-(1,3-dimethylbutyl)-N'-phenyl-p-phenylenediamine

Comments on Table 4 and Table 5:

[0132] As apparent from the results shown in Table 4 and Table 5, it has been confirmed that in Examples 28 to 37 falling in the scope of the present invention, 100 % modulus after heat aging is excellent and an elongation at break is high as compared with those of Comparative Examples 11 to 14 falling outside the scope of the present invention.

[0133] It has been found that the rubber compositions having an excellent heat aging-resistant property can be obtained by using the aforementioned various hydrazide compounds of the present invention. Further, it has been found that the rubber compositions having further excellent heat aging-resistant property can be obtained by using the above hydrazide compounds in combination with the diphenyldiamine based antioxidants.

Synthetic Examples 19 to 24

[0134] Among the sulfonic acid hydrazone derivatives represented by Formula (IV) in the present invention, six typical compounds of N'-(1-methylethylidene)benzenesulfonohydrazide, N'-benzylidenebenzenesulfonohydrazide, N'-(2-furylmethylene)benzenesulfonohydrazide, N'-diphenylmethylenbenzenesulfonohydrazide, N'-benzylidene-p-toluenesulfonohydrazide and N'-benzylidene-1-naphthalenesulfonohydrazide were synthesized by the following methods:

Synthetic Example 19: synthesis of N'-(1-methylethylidene)benzenesulfonohydrazide

[0135] A four neck flask (1 liter) equipped with a thermometer, a reflux condenser and a stirrer was charged with 86 g (0.5 mol) of benzenesulfonohydrazide, 0.95 g (0.005 mol) of p-toluenesulfonic acid and 700 ml of acetone and then heated under reflux for about 5 hours. The reaction liquid was cooled down to 20°C or lower, and then crystal was filtered off and dried under reduced pressure, whereby white crystal was obtained.

[0136] The amount yielded in this reaction was 97.5 g (0.46 mol), and the yield was 92 %.

Melting point: 145°C

¹H-NMR (DMSO) 1.77 (s, 6H), 7.50 to 7.90 (m, 5H), 10.05 (b, 1H)

Synthetic Example 20: synthesis of N'-benzylidenebenzenesulfonohydrazide

[0137] A four neck flask (1 liter) equipped with a thermometer, a reflux condenser and a stirrer was charged with 86 g (0.5 mol) of benzenesulfonohydrazide and 700 ml of methanol, and 63.6 g (0.6 mol) of benzaldehyde was dropwise added thereto in one hour while stirring at room temperature and heated under reflux for about 5 hours. The reaction liquid was cooled down to 20°C or lower, and then crystal was filtered off and dried under reduced pressure, whereby white crystal was obtained.

[0138] The amount yielded in this reaction was 115 g (0.445 mol), and the yield was 89 %.

Melting point: 112°C

¹H-NMR (DMSO) 7.20 to 8.40 (m, 12H)

Synthetic Example 21: synthesis of N'-(2-furylmethylene)benzenesulfonohydrazide

[0139] A four neck flask (1 liter) equipped with a thermometer, a reflux condenser and a stirrer was charged with 86 g (0.5 mol) of benzenesulfonohydrazide and 700 ml of methanol, and 57.6 g (0.6 mol) of furfural was dropwise added thereto in one hour while stirring at room temperature and heated under reflux for about 5 hours. The reaction liquid was cooled down to 20°C or lower, and then crystal was filtered off and dried under reduced pressure, whereby white crystal was obtained.

[0140] The amount yielded in this reaction was 94 g (0.37 mol), and the yield was 75 %.

Melting point: 134°C

¹H-NMR (DMSO) 6.52 (m, 1H), 6.80 (m, 1H), 7.50 to 7.90 (m, 7H), 11.51 (s, 1H)

Synthetic Example 22: synthesis of N'-diphenylmethylenbenzenesulfonohydrazide

[0141] A four neck flask (2 liters) equipped with a thermometer, a reflux condenser and a stirrer was charged with 78.4 g (0.4 mol) of benzophenone hydrazone, 64.6 g (0.64 mol) of triethylamine and 1 liter of ether, and 105.6 g (0.6 mol) of benzenesulfonic acid chloride was dropwise added thereto in one hour while stirring at room temperature and then heated under reflux for 72 hours. The reaction liquid was cooled down to 20°C and then washed (separated) twice with

500 ml of deionized water. The ether layer was dried over anhydrous magnesium sulfate and filtered off, and then the mother liquid was concentrated by means of a rotary evaporator to obtain reddish yellow crystal. This crude crystal was added to 1 liter of diethyl ether and heated under reflux for 30 minutes, and then the crystal was filtered off at 30°C. This was dried under reduced pressure to thereby obtain white crystal.

[0142] The amount yielded in this reaction was 94.1 g (0.28 mol), and the yield was 70 %.

Melting point: 190°C

¹H-NMR (DMSO) 7.10 to 8.00 (m, 15H), 10.52 (s, 1H)

Synthetic Example 23: synthesis of N'-benzylidene-p-toluenesulfonohydrazide

[0143] A four neck flask (1 liter) equipped with a thermometer, a reflux condenser and a stirrer was charged with 93.0 g (0.5 mol) of p-toluenesulfonohydrazide and 700 ml of methanol, and 63.6 g (0.6 mol) of benzaldehyde was dropwise added thereto in one hour while stirring at room temperature and heated under reflux for about 5 hours. The reaction liquid was cooled down to 20°C or lower, and then crystal was filtered off and dried under reduced pressure, whereby white crystal was obtained.

[0144] The amount yielded in this reaction was 123 g (0.45 mol), and the yield was 90 %.

Melting point: 126°C

¹H-NMR (DMSO) 2.35 (s, 3H), 7.20 to 7.80 (m, 10H), 10.10 (b, 1H)

Synthetic Example 24: synthesis of N'-benzylidene-1-naphthalenesulfonohydrazide

[0145] A four neck flask (1 liter) equipped with a thermometer, a reflux condenser and a stirrer was charged with 111 g (0.5 mol) of 1-naphthalenesulfonohydrazide and 700 ml of methanol, and 63.6 g (0.6 mol) of benzaldehyde was dropwise added thereto in one hour while stirring at room temperature and heated under reflux for about 5 hours. The reaction liquid was cooled down to 20°C or lower, and then crystal was filtered off and dried under reduced pressure, whereby white crystal was obtained.

[0146] The amount yielded in this reaction was 145 g (0.47 mol), and the yield was 94 %.

Melting point: 153°C

¹H-NMR (DMSO) 7.20 to 8.80 (m, 13H), 10.50 (b, 1H)

Examples 38 to 51 and Comparative Examples 15 to 16

[0147] Rubber compositions containing the components shown in the following Tables 6 to 7 and Tables 9 to 10 were mixed by means of a Banbury mixer and then molded to sheets (160 mm × 160 mm) having a thickness of about 2 mm, followed by pressing cure at 145°C for 30 minutes.

[0148] The vulcanized rubbers thus obtained were subjected to a hardness test and a tensile test before heat aging and after heat aging in the air at 100°C for 48 hours to determine a hardness (Hd), a 300 % modulus (M300), an elongation at break (Eb) and a tensile strength at break (Tb). The values thereof were shown by index, wherein the values of Comparative Examples 15 and 16 were set at 100

[0149] These results are shown in the following Tables 8 and 11.

Table 6

Components	Parts by weight
Natural rubber	100
Reinforcing filler *1	50
Stearic acid	2.0
Zinc oxide	3.0
Antioxidant *2	1.0
Sulfonic hydrazide	Table 7
Vulcanization accelerator *3	0.8
Sulfur	1.3

*1: HAF grade carbon black

*2: Nocrac 6C (manufactured by Ohuchi Shinko Chemical Ind. Co., Ltd.) [N-(1,3-dimethylbutyl)-N'-phenyl-p-phenylenediamine]

*3: Nocceler NS-P (manufactured by Ohuchi Shinko Chemical Ind. Co., Ltd.) [N-tert-butyl-2-benzothiazolyl sulfenamide]

Table 7

	Sulfonohydrazide	Blending amount (part by weight)
Comparative Example 15	No addition	-
Example 38	N'-diphenylmethylenbenzenesulfonohydrazide	1.0
Example 39	N'-diphenylmethylenbenzenesulfonohydrazide	2.0
Example 40	N'-diphenylmethylenbenzenesulfonohydrazide	4.0
Example 41	N'-(1-methylethylidene)benzenesulfonohydrazide	2.0
Example 42	N'-(1,3-dimethylbutylidene)benzenesulfonohydrazide	2.0
Example 43	N'-(2-furylmethylidene)benzenesulfonohydrazide	2.0
Example 44	N'-diphenylmethylen-p-toluenesulfonohydrazide	2.0

Table 8

	Before heat aging				After heat aging			
	Hd	M300	Eb	Tb	Hd	M300	Eb	Tb
Comparative Example 15	100	100	100	100	100 (113.8)	100 (160.6)	100 (71.9)	100 (78.9)
Example 38	101.7	101.2	100.9	100.3	97.0 (108.8)	88.7 (140.7)	103.4 (73.6)	104.7 (82.4)
Example 39	103.4	102.8	102.4	101.0	95.5 (105.0)	83.6 (130.5)	113.8 (79.9)	106.8 (83.5)

Table 8 (continued)

	Before heat aging				After heat aging			
	Hd	M300	Eb	Tb	Hd	M300	Eb	Tb
Example 40	105.2	103.8	103.1	101.0	95.5 (103.3)	82.4 (127.5)	115.4 (80.5)	108.1 (84.5)
Example 41	101.7	100.7	100.6	100.1	95.5 (106.8)	90.6 (144.6)	103.7 (74.1)	102.1 (80.6)
Example 42	101.7	102.2	101.3	100.6	95.5 (106.8)	85.9 (135.0)	109.8 (78.0)	102.2 (80.2)
Example 43	103.4	103.2	101.6	99.6	95.5 (105.0)	85.2 (132.7)	110.6 (78.2)	100.4 (79.5)
Example 44	101.7	101.0	100.8	100.4	95.5 (106.8)	85.0 (135.1)	103.8 (74.0)	101.9 (80.1)
Numeral in a parenthesis is a change rate before and after heat aging								

Table 9

Components	Parts by weight
Synthetic rubber *4	100
Reinforcing filler *5	60
Stearic acid	2.0
Aromatic oil	3.0
Zinc oxide	3.0
Antioxidant *6	1.0
Sulfonohydrazide	Table 10
Vulcanization accelerator 1 *7	0.5
Vulcanization accelerator 2 *8	0.5
Vulcanization accelerator 3 *9	0.5
Sulfur	1.3

*4: JSR 1502 (manufactured by Japan Synthetic Rubber Co., Ltd.)

*5: HAF grade carbon black

*6: Nocrac 6C (manufactured by Ohuchi Shinko Chemical Ind. Co., Ltd.) [N-(1,3-dimethylbutyl)-N'-phenyl-p-phenylenediamine]

*7: Nocceler NS-P (manufactured by Ohuchi Shinko Chemical Ind. Co., Ltd.) [N-tert-butyl-2-benzothiazolyl sulfenamide]

*8: Nocceler DM-P (manufactured by Ohuchi Shinko Chemical Ind. Co., Ltd.) [dibenzothiazyl disulfide]

*9: Nocceler D (manufactured by Ohuchi Shinko Chemical Ind. Co., Ltd.) [1,3-diphenylguanidine]

Table 10

	Sulfonohydrazide	Blending amount (part by weight)
Comparative Example 16	No addition	-
Example 45	N'-diphenylmethylenebenzenesulfonohydrazide	1.0
Example 46	N'-diphenylmethylenebenzenesulfonohydrazide	2.0
Example 47	N'-diphenylmethylenebenzenesulfonohydrazide	4.0
Example 48	N'-(1-methylethylidene)benzenesulfonohydrazide	2.0
Example 49	N'-(1,3-dimethylbutylidene)benzenesulfonohydrazide	2.0
Example 50	N'-(2-furylmethylidene)benzenesulfonohydrazide	2.0
Example 51	N'-diphenylmethylenep-toluenesulfonohydrazide	2.0

Table 11

	Before heat aging				After heat aging			
	Hd	M300	Eb	Tb	Hd	M300	Eb	Tb
Comparative Example 16	100	100	100	100	100 (112.3)	100 (157.1)	100 (72.4)	100 (81.9)
Example 45	101.8	100.8	100.3	100.2	98.4 (108.6)	92.8 (144.7)	105.5 (76.2)	102.3 (83.6)
Example 46	103.5	102.3	101.1	100.5	96.9 (105.1)	88.2 (135.5)	112.3 (80.4)	105.0 (85.6)
Example 47	105.3	102.8	101.4	100.7	96.9 (103.3)	89.3 (136.5)	113.1 (80.8)	105.5 (85.7)
Example 48	101.8	100.3	100.2	100.3	98.4 (108.6)	94.0 (147.2)	106.0 (76.6)	102.8 (83.9)
Example 49	101.8	101.7	100.7	100.0	96.9 (106.9)	89.5 (138.3)	109.1 (78.5)	105.6 (86.5)
Example 50	103.5	102.8	100.3	99.7	96.9 (105.1)	90.4 (138.1)	108.3 (78.2)	102.6 (84.2)
Example 51	101.8	100.2	100.7	99.8	96.9 (106.9)	90.8 (142.4)	107.4 (77.3)	102.4 (84.0)
Numeral in a parenthesis is a change rate before and after heat aging								

Comments on Tables 8 and 11:

[0150] As apparent from the results shown in Tables 8 and 11, it has been confirmed that in Examples 38 to 51 falling in the scope of the present invention, a hardness (Hd) can be reduced even after heat aging and an elongation at break (Eb) and a tensile strength at break (Tb) are excellent as compared with those of Comparative Examples 15 to 16 falling outside the scope of the present invention.

Examples 52 to 60 and Comparative Examples 17 to 21

[0151] Rubber compositions were prepared in the compounding recipes shown in the following Table 12. Tires having

a tire size of 3700R57 were produced to apply the respective rubber compositions shown in Table 12 to a tire rubber member (tread member) shown in Fig. 1. The hydrazide compounds A to J were compounded in the equimolar amounts respectively.

[0152] The respective experimental tires thus obtained were evaluated for a tire temperature, an abrasion resistance, a cut resistance and a workability by the following evaluation methods. The results thereof are shown in the following Table 12.

Evaluation of tire temperature:

[0153] A drum test was carried out at a fixed speed under a step road condition to measure a temperature in a position of a fixed depth of a tire tread and the results are shown by index, wherein the value of a control (Comparative Example 17 in which no hydrazide compound was added) was set at 100. The smaller the value of the index is, the larger the effect on low heat generation property is.

Evaluation of abrasion resistance:

[0154] The abrasion resistance was evaluated by calculating a value according to the following equation for the tread rubber of the tire after running for 2000 hours:

$$\text{travel distance}/(\text{groove depth before running} - \text{groove depth after running})$$

and showing the value by index, wherein the value of a control (Comparative Example 17) was set at 100. The larger the value of the index is, the larger the effect on improving the abrasion resistance is.

Evaluation of cut resistance:

[0155] The cut resistance (rupture resistance) was evaluated by determining an area rate per tread rubber surface 30 cm × 30 cm in which the rubber does not peel off in the tire after running for 2000 hours and showing it by index, wherein the value of a control (Comparative Example 17) was set at 100. The larger the value of the index is, the larger the effect on improving the cut resistance is.

Evaluation of workability:

[0156] The Mooney viscosity ML_{1+4} (130°C) was measured and shown by index, wherein the value of a control (Comparative Example 18 in which conventional 3-hydroxy-2-naphthohydrazide described in Japanese Patent Laid-Open No. Hei 4-136048 was added) was set at 100. The larger the value of the index is, the larger the effect on improving the workability is.

Table 12

	Comparative Example	Example						
		52	53	54	55	56	57	58
Compo- nents	Natural rubber	100	100	100	100	100	100	100
	Carbon kind	A	A	A	A	A	A	A
	Black amount	45	45	45	45	45	45	45
	Stearic acid	2	2	2	2	2	2	2
	Paraffin wax	2	2	2	2	2	2	2
	Antioxidant *1	1	1	1	1	1	1	1
	ZnO	3	3	3	3	3	3	3
	Vulcanization accelerator *2	1	1	1	1	1	1	1
	Sulfur	1.5	1.5	1.5	1.5	1.5	1.5	1.5
	Hydrazide compound amount	-	A	B	C	D	E	F
		-	1.07	1.13	1.19	1.23	0.85	1.03
Evalu- ation	Tire temperature	100	83	85	88	80	83	82
	Abrasion resistance	100	102	103	102	100	99	100
	Cut resistance	100	101	105	101	102	100	100
	Workability	81	89	88	84	82	80	78

Kind of carbon black: A: N220 (N₁SA = 120, DBP = 119)

*1: Santflex 13 (N-(1,3-dimethyl)-N'-phenyl-phenylenediamine)

*2: N-tert-butyl-2-benzothiazole sulfenamide

Table 12 (continued)

	Comparative Example			Example	Comparative Example	Example
	18	19	20			
Natural rubber	100	100	100	100	100	NR/SBR 70/30
Carbon kind amount	A	A	A	A	A	A
Black	45	45	40	45	75	45
Stearic acid	2	2	2	2	2	2
Paraffin wax	2	2	2	2	2	2
Antioxidant #1	1	1	1	1	1	1
ZnO	3	3	3	3	3	3
Vulcanization Accelerator #2	1	1	1	1	1	1
Sulfur	1.5	1.5	1.5	1.5	1.5	1.5
Hydrazide compound amount	I	J	-	H	A	A
	1.0	1.0	-	1.1	1.07	1.07
Tire temperature	88	81	88	80	115	89
Abrasion resistance	100	100	83	100	110	109
Cut resistance	101	99	81	100	125	120
Workability	100	135	75	100	130	91

[0157] In Table 12, the hydrazide compounds A to J represent the following compounds:

A: 3-hydroxy-N'-(1-methylethylidene)-2-naphthohydrazide

- B: 3-hydroxy-N'-(1-methylpropylidene)-2-naphthohydrazide
 C: 3-hydroxy-N'-(1-methylbutylidene)-2-naphthohydrazide
 D: 3-hydroxy-N'-(1,3-dimethylbutylidene)-2-naphthohydrazide
 E: N'-(1-methylethylidene)salicylohydrazide
 F: N'-(1,3-dimethylbutylidene)salicylohydrazide
 G: 1-hydroxy-N'-(1,3-dimethylbutylidene)-2-naphthohydrazide
 H: N²,N⁴-di(1-methylethylidene)isophthalodihydrazide
 I: 3-hydroxy-2-naphthohydrazide
 J: isophthalodihydrazide

Comments on Table 12:

[0158] As apparent from the results shown in Table 12, it has been confirmed that Examples 52 to 60 falling in the scope of the present invention are improved in workability to a large extent while keeping a tire temperature, an abrasion resistance and a cut resistance equal or higher as compared with those of Comparative Examples 17 to 21 falling outside the scope of the present invention.

[0159] To observe the individual cases, no heat generation property-improving agent was added in Comparative Example 17 (control), and it can be found in this case that the workability is extremely degraded. In Comparative Example 18, 3-hydroxy-2-naphthohydrazide described in Japanese Patent Laid-Open No. Hei 4-136048 which was a conventional technique was added and in Comparative Example 19, isophthalodihydrazide was added. It can be found that the low heat generation property is achieved but the workability is extremely deteriorated. In Comparative Example 20, the amount of carbon black is reduced by 5 weight parts compared with Comparative Example 17, and it can be found in this case that balance among the workability, the abrasion resistance and the cut resistance is not improved. In Comparative Example 21, 3-hydroxy-N'-(1-methylethylidene)-2-naphthohydrazide which is the chemical substance of the present invention is used. However, carbon black is used in a large amount, and therefore it can be found that the tire temperature is elevated though the abrasion resistance and the cut resistance are improved, and that the workability is deteriorated as well to a large extent.

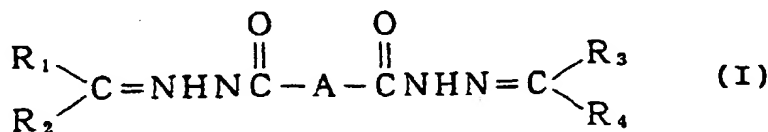
[0160] In contrast with this, it has been confirmed that in any of Examples 52 to 60 each of which falls in the scope of the present invention, the workability is improved to a large extent while keeping the tire temperature, the abrasion resistance and the cut resistance equal or higher.

Industrial Applicability

[0161] The rubber composition of the present invention can be used for industrial articles such as rubber vibration isolators, belts and hoses as well as tire materials such as tire treads, undertreads, carcasses, side walls and beads. In particular, the use thereof for a tire tread can provide a tire having a low heat generation property.

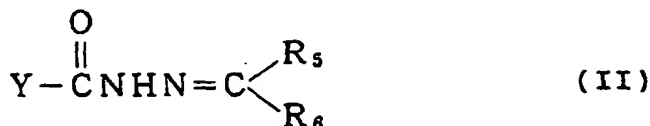
Claims

1. A rubber composition prepared by compounding 0.05 to 20 parts by weight of at least one selected from the group consisting of hydrazide compounds represented by the following Formulas (I) to (IV) per 100 parts by weight of a rubber component comprising at least one rubber selected from the group consisting of natural rubber and synthetic rubber:



wherein A represents one selected from the group consisting of an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, a hydantoin ring which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, and a saturated or unsaturated linear hydrocarbon having 1 to 18 carbon atoms; R₁ to R₄ each represent hydrogen, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group or an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, and each of R₁ to R₄ may be the same or different, and when R₁ and R₂ and/or R₃ and R₄ are alkyl groups,

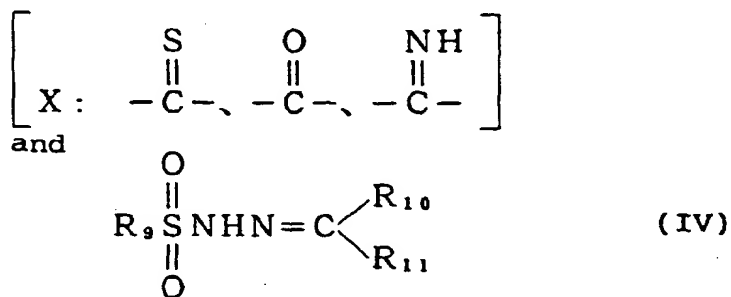
R₁ may be bonded to R₂ and R₃ may be bonded to



R₄ to form rings; wherein Y represents hydrogen, an amino group, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group, an alkenyl group, an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, a pyridyl group or hydrazino group; R₅ and R₆ each represent hydrogen, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group, an alkenyl group or an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, and each of R₅ and R₆ may be the same or different, and when R₅ and R₆ are alkyl groups, R₅ may be bonded to R₆ to form a ring;



wherein R₇ and R₈ each represent an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group, an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, an alkenyl group, an amino group or an alkylamino group and each of R₇ and R₈ may be the same or different; and X represents a single bond or any of the groups represented by the following formulas;



wherein R₉ represents hydrogen, an alkoxy group, an amino group, a substituted amino group, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group, an alkenyl group or an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms; and R₁₀ and R₁₁ each represent hydrogen, an alkyl group having 1 to 18 carbon atoms, a cycloalkyl group, an alkenyl group or an aromatic group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, and each of R₁₀ and R₁₁ may be the same or different, and when R₁₀ and R₁₁ are alkyl groups, R₁₀ may be bonded to R₁₁ to form a ring.

2. The rubber composition as described in claim 1, containing 30 phr or more of natural rubber or polyisoprene rubber as the rubber component.
3. The rubber composition as described in claim 1 or 2 prepared by further compounding 20 to 150 parts by weight of a reinforcing filler.
4. The rubber composition as described in claim 3, wherein the reinforcing filler is carbon black.
5. The rubber composition as described in any of claims 1 to 4, wherein A in Formula (I), Y in Formula (II), R₇ in For-

mula (III) and R_9 in Formula (IV) in the hydrazide compounds represented by Formulas (I) to (IV) described above each represent a phenyl group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms, or a naphthyl group which may be substituted with at least one substituent containing at least one atom of carbon, sulfur, oxygen and nitrogen atoms.

6. The rubber composition as described in claim 5, wherein the compound represented by Formula (I) described above is N^2, N^4 -di(1-methylethylidene)isophthalodihydrazide, N^2, N^4 -di(1-methylpropylidene)isophthalodihydrazide or N^2, N^4 -di(1,3-dimethylbutylidene)isophthalodihydrazide.
7. The rubber composition as described in claim 5, wherein the hydrazide compound represented by Formula (II) described above is N' -(1-methylethylidene)salicylohydrazide, N' -(1-methylpropylidene)salicylohydrazide, N' -(1,3-dimethylbutylidene)salicylohydrazide, N' -(2-furylmethylene)salicylohydrazide, 1-hydroxy- N' -(1-methylethylidene)-2-naphthohydrazide, 1-hydroxy- N' -(1-methylpropylidene)-2-naphthohydrazide, 1-hydroxy- N' -(1,3-dimethylbutylidene)-2-naphthohydrazide, 1-hydroxy- N' -(2-furylmethylene)-2-naphthohydrazide, 3-hydroxy- N' -(1-methylethylidene)-2-naphthohydrazide, 3-hydroxy- N' -(1-methylpropylidene)-2-naphthohydrazide, 3-hydroxy- N' -(1,3-dimethylbutylidene)-2-naphthohydrazide or 3-hydroxy- N' -(2-furylmethylene)-2-naphthohydrazide.
8. The rubber composition as described in claim 5, wherein the hydrazide compound represented by Formula (III) described above is N -benzoyl- N' -phenylhydrazide, 1-benzamidedguanidine or 1-benzoylsemicarbazide.
9. The rubber composition as described in claim 5, wherein the hydrazide compound represented by Formula (IV) described above is N' -(1-methylethylidene)benzenesulfonohydrazide, N' -(1-methylpropylidene)benzenesulfonohydrazide, N' -(1,3-dimethylbutylidene)benzenesulfonohydrazide, N' -(1-phenylethylidene)benzenesulfonohydrazide, N' -(2-hydroxybenzylidene)benzenesulfonohydrazide, N' -diphenylmethylenbenzenesulfonohydrazide, N' -(2-furylmethylene)benzenesulfonohydrazide, N' -(1-methylethylidene)- p -toluenesulfonohydrazide, N' -(1-methylpropylidene)- p -toluenesulfonohydrazide, N' -(1,3-dimethylbutylidene)- p -toluenesulfonohydrazide, N' -benzylidene- p -toluenesulfonohydrazide, N' -(1-phenylethylidene)- p -toluenesulfonohydrazide, N' -(2-hydroxybenzylidene)- p -toluenesulfonohydrazide, N' -diphenylmethylen- p -toluenesulfonohydrazide or N' -(2-furylmethylene)- p -toluenesulfonohydrazide.
10. The rubber composition as described in any of claims 1 to 9, prepared by further compounding 0.1 to 5.0 parts by weight of at least one selected from antioxidants of naphthylamine base, p -phenylenediamine base, hydroquinone derivative, bisphenol base, trisphenol base, polyphenol base, diphenylamine base, quinoline base, thiobisphenol base and hindered phenol base.
11. A pneumatic tire characterized by using a rubber composition prepared by compounding 0.05 to 5 parts by weight of at least one selected from the group consisting of the hydrazide compounds represented by Formulas (I) to (IV) described above per 100 parts by weight of a rubber component comprising natural rubber and diene based rubber as principal components.
12. The pneumatic tire as described in claim 11, wherein the rubber composition prepared by compounding 0.05 to 5 parts by weight of at least one selected from the group consisting of the hydrazide compounds represented by Formulas (I) to (IV) described above per 100 parts by weight of the rubber component comprising natural rubber and diene based rubber as principal components is used for a tire tread part.
13. The pneumatic tire as described in claim 12, wherein the rubber composition prepared by compounding 0.05 to 5 parts by weight of at least one selected from the group consisting of the hydrazide compounds represented by Formula (II) described above per 100 parts by weight of the rubber component comprising natural rubber and diene based rubber as principal components is used for a tire tread part.
14. The pneumatic tire as described in claim 13, wherein the hydrazide compound represented by Formula (II) described above is N' -(1-methylethylidene)salicylohydrazide, N' -(1-methylpropylidene)salicylohydrazide, N' -(1,3-dimethylbutylidene)salicylohydrazide, N' -(2-furylmethylene)salicylohydrazide, 1-hydroxy- N' -(1-methylethylidene)-2-naphthohydrazide, 1-hydroxy- N' -(1-methylpropylidene)-2-naphthohydrazide, 1-hydroxy- N' -(1,3-dimethylbutylidene)-2-naphthohydrazide, 1-hydroxy- N' -(2-furylmethylene)-2-naphthohydrazide, 3-hydroxy- N' -(1-methylethylidene)-2-naphthohydrazide, 3-hydroxy- N' -(1-methylpropylidene)-2-naphthohydrazide, 3-hydroxy- N' -(1,3-dimethylbutylidene)-2-naphthohydrazide or 3-hydroxy- N' -(2-furylmethylene)-2-naphthohydrazide.

15. The pneumatic tire as described in claim 12, wherein 30 to 70 parts by weight of carbon black having a specific surface area by nitrogen adsorption (N_2SA) of 30 to 180 m^2/g and a dibutyl phthalate absorption (DBP) of 60 to 200 ml/100 g is compounded per 100 parts by weight of the rubber component comprising natural rubber and diene base rubber as principal components; and the hydrazide compound is one in which A in Formula (I) described above is an aromatic group.

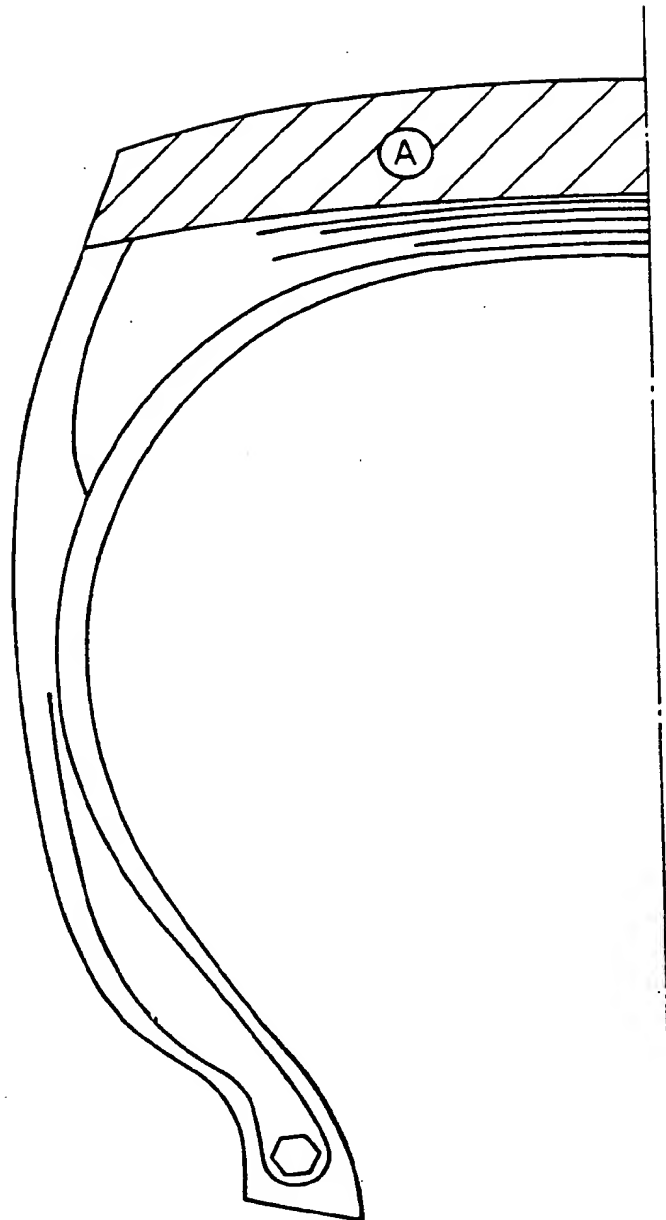
16. The pneumatic tire as described in claim 13, wherein 30 to 70 parts by weight of carbon black having a specific surface area by nitrogen adsorption (N_2SA) of 30 to 180 m^2/g and a dibutyl phthalate absorption (DBP) of 60 to 200 ml/100 g is compounded per 100 parts by weight of the rubber component comprising natural rubber and diene based rubber as principal components; and Y in Formula (II) described above is an aromatic group substituted with a hydroxyl group or an amino group.

17. A hydrazone derivative represented by Formula (V):



wherein Z represents 3-hydroxy-2-naphthyl, 1-hydroxy-2-naphthyl, 2-hydroxyphenyl or 2,6-dihydroxyphenyl group.

FIG. 1



A: TREAD PART

INTERNATIONAL SEARCH REPORT

International application No.

PCT/JP98/01530

A. CLASSIFICATION OF SUBJECT MATTER Int.Cl ⁶ C08L21/00, C08K3/04, 5/24, 5/41, B60C1/00		
According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED Minimum documentation searched (classification system followed by classification symbols) Int.Cl ⁶ C08L7/00-21/00, C08K3/04, 5/24-5/26, 5/41-5/42		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched		
Electronic data base consulted during the international search (name of data base and, where practicable, search terms used) CAS ONLINE		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
E, X	JP, 10-139934, A (Bridgestone Corp.), May 26, 1998 (26. 05. 98), Claims ; Par. Nos. [0018], [0019] (Family: none)	1-7, 10-16
X Y	JP, 62-215640, A (Bridgestone Corp.), September 22, 1987 (22. 09. 87), Claims (Family: none)	1-5, 9-13 15, 16
X	JP, 59-78250, A (CIBA-Geigy AG.), May 7, 1984 (07. 05. 84), Claims (Family: none)	1-5, 10
X	JP, 62-220534, A (Adeka Argus Chemical Co., Ltd.), September 28, 1987 (28. 09. 87), Page 2, lower right column, 6th line from the bottom to page 3, upper left column, line 7 (Family: none)	1-5, 10
X	JP, 9-40810, A (Three Bond Co., Ltd.), February 10, 1997 (10. 02. 97), Column 3, lines 25 to 27 (Family: none)	1-5, 10
<input checked="" type="checkbox"/> Further documents are listed in the continuation of Box C. <input type="checkbox"/> See patent family annex.		
* Special categories of cited documents: "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier document but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family		
Date of the actual completion of the international search May 29, 1998 (29. 05. 98)		Date of mailing of the international search report June 9, 1998 (09. 06. 98)
Name and mailing address of the ISA/ Japanese Patent Office		Authorized officer
Facsimile No.		Telephone No.

Form PCT/ISA/210(second sheet)(July 1997)

INTERNATIONAL SEARCH REPORT

International application No.

PCT/JP98/01530

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	JP, 7-292157, A (Bridgestone Corp.), November 7, 1995 (07. 11. 95), Claims & EP, 679682, A1	15, 16
Y	JP, 8-175102, A (Bridgestone Corp.), July 9, 1996 (09. 07. 96), Claims (Family: none)	15, 16
A	JP, 4-136048, A (Bridgestone Corp.), May 11, 1992 (11. 05. 92), Claims & EP, 478274, A1	1-17

Form PCI/ISA/210(continuation of second sheet)(July 1997)

THIS PAGE BLANK (USPTO)